



US01141113B2

(12) **United States Patent**  
**Lin et al.**

(10) **Patent No.:** **US 11,411,113 B2**  
(45) **Date of Patent:** **\*Aug. 9, 2022**

(54) **FINFETS AND METHODS OF FORMING FINFETS**

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(\*) Notice: Subject to any disclaimer, the term of this patent is extended or adjusted under 35 U.S.C. 154(b) by 32 days.  
  
This patent is subject to a terminal disclaimer.

(21) Appl. No.: **16/927,082**

(22) Filed: **Jul. 13, 2020**

(65) **Prior Publication Data**  
US 2020/0343384 A1 Oct. 29, 2020

**Related U.S. Application Data**

(60) Division of application No. 16/229,118, filed on Dec. 21, 2018, now Pat. No. 10,714,620, which is a (Continued)

(51) **Int. Cl.**  
**H01L 29/66** (2006.01)  
**H01L 29/78** (2006.01)  
(Continued)

(52) **U.S. Cl.**  
CPC ..... **H01L 29/7851** (2013.01); **H01L 21/0214** (2013.01); **H01L 21/0217** (2013.01); **H01L 21/02167** (2013.01); **H01L 21/0332** (2013.01); **H01L 21/76843** (2013.01); **H01L 21/76897** (2013.01); **H01L 21/823475** (2013.01); **H01L 23/5283** (2013.01); **H01L 29/41791** (2013.01); **H01L 29/66545** (2013.01);  
(Continued)

(58) **Field of Classification Search**  
CPC ..... H01L 29/66795; H01L 29/785; H01L 2029/7858  
See application file for complete search history.

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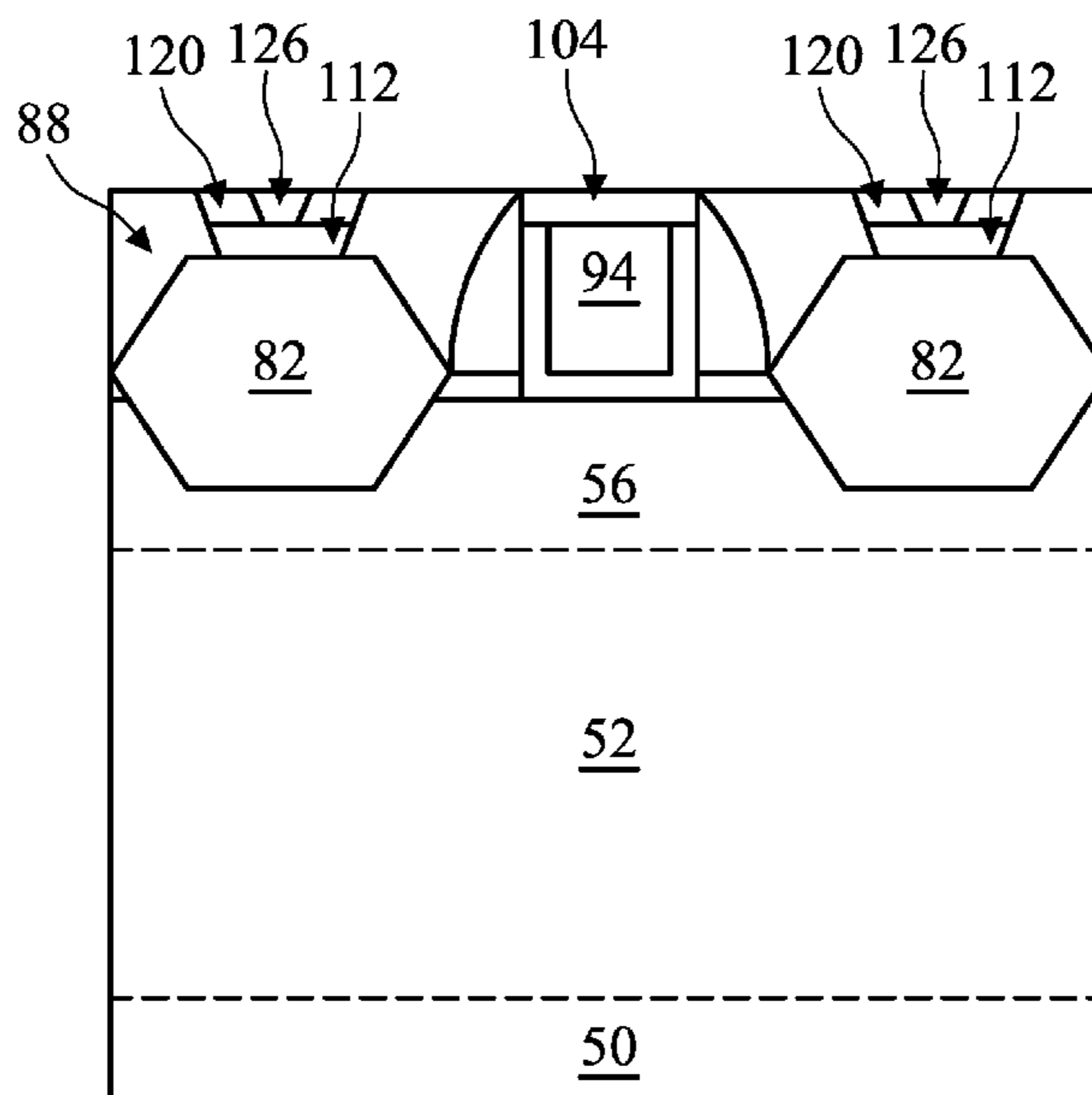
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(57) **ABSTRACT**

An embodiment is a method including recessing a gate electrode over a semiconductor fin on a substrate to form a first recess from a top surface of a dielectric layer, forming a first mask in the first recess over the recessed gate electrode, recessing a first conductive contact over a source/drain region of the semiconductor fin to form a second recess from the top surface of the dielectric layer, and forming a second mask in the second recess over the recessed first conductive contact.

**20 Claims, 38 Drawing Sheets**



<b>Related U.S. Application Data</b>	(56)	<b>References Cited</b>
continuation of application No. 15/991,680, filed on May 29, 2018, now Pat. No. 10,164,114, which is a division of application No. 15/455,603, filed on Mar. 10, 2017, now Pat. No. 9,985,135.		U.S. PATENT DOCUMENTS
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(51) <b>Int. Cl.</b> <i>H01L 29/417</i> (2006.01) <i>H01L 21/768</i> (2006.01) <i>H01L 21/02</i> (2006.01) <i>H01L 21/033</i> (2006.01) <i>H01L 21/8234</i> (2006.01) <i>H01L 23/528</i> (2006.01) <i>H01L 21/8238</i> (2006.01)		
(52) <b>U.S. Cl.</b> CPC .. <i>H01L 29/66795</i> (2013.01); <i>H01L 21/76834</i> (2013.01); <i>H01L 21/76883</i> (2013.01); <i>H01L 21/823431</i> (2013.01); <i>H01L 21/823814</i> (2013.01); <i>H01L 21/823821</i> (2013.01); <i>H01L 21/823878</i> (2013.01)		

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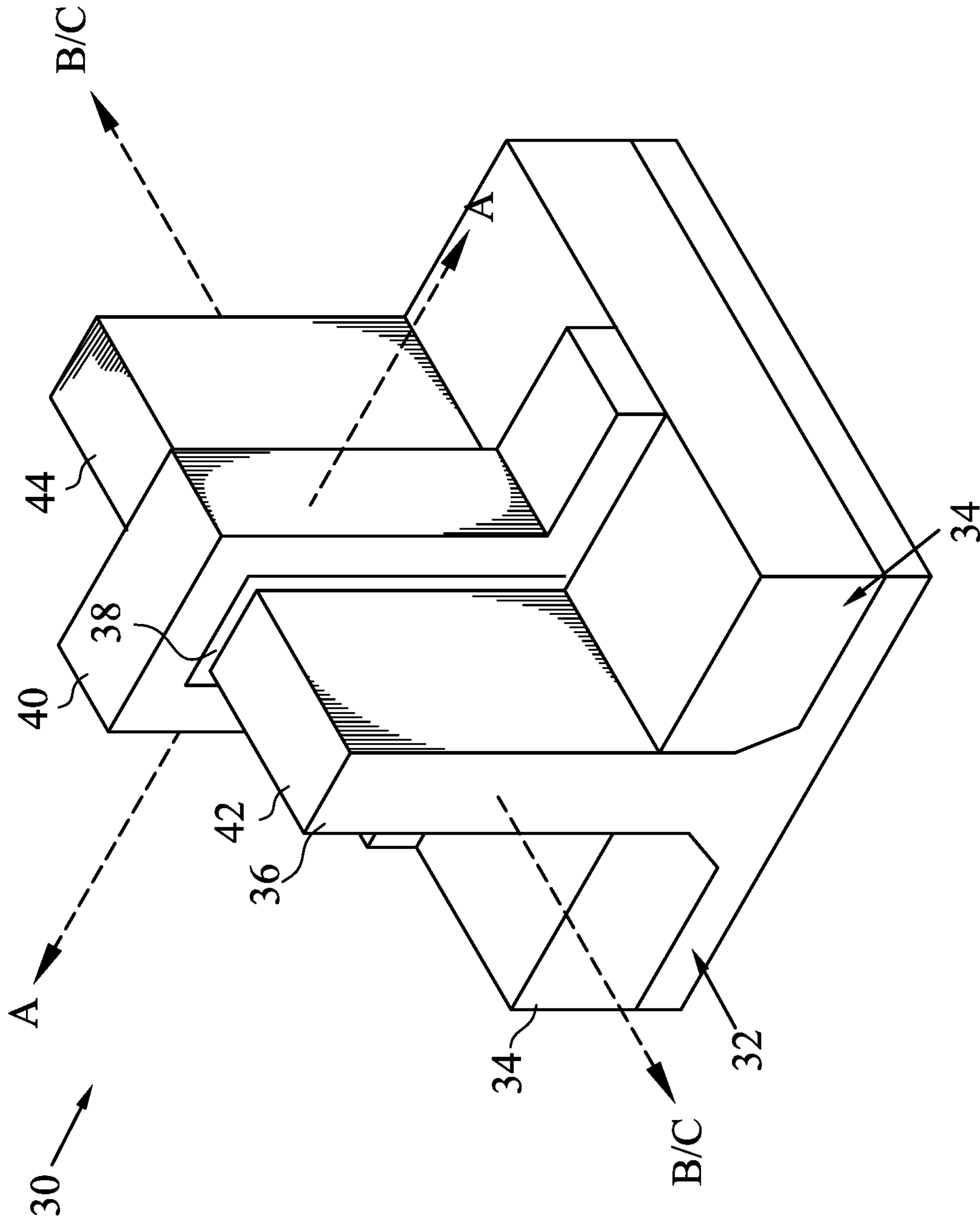


Figure 1

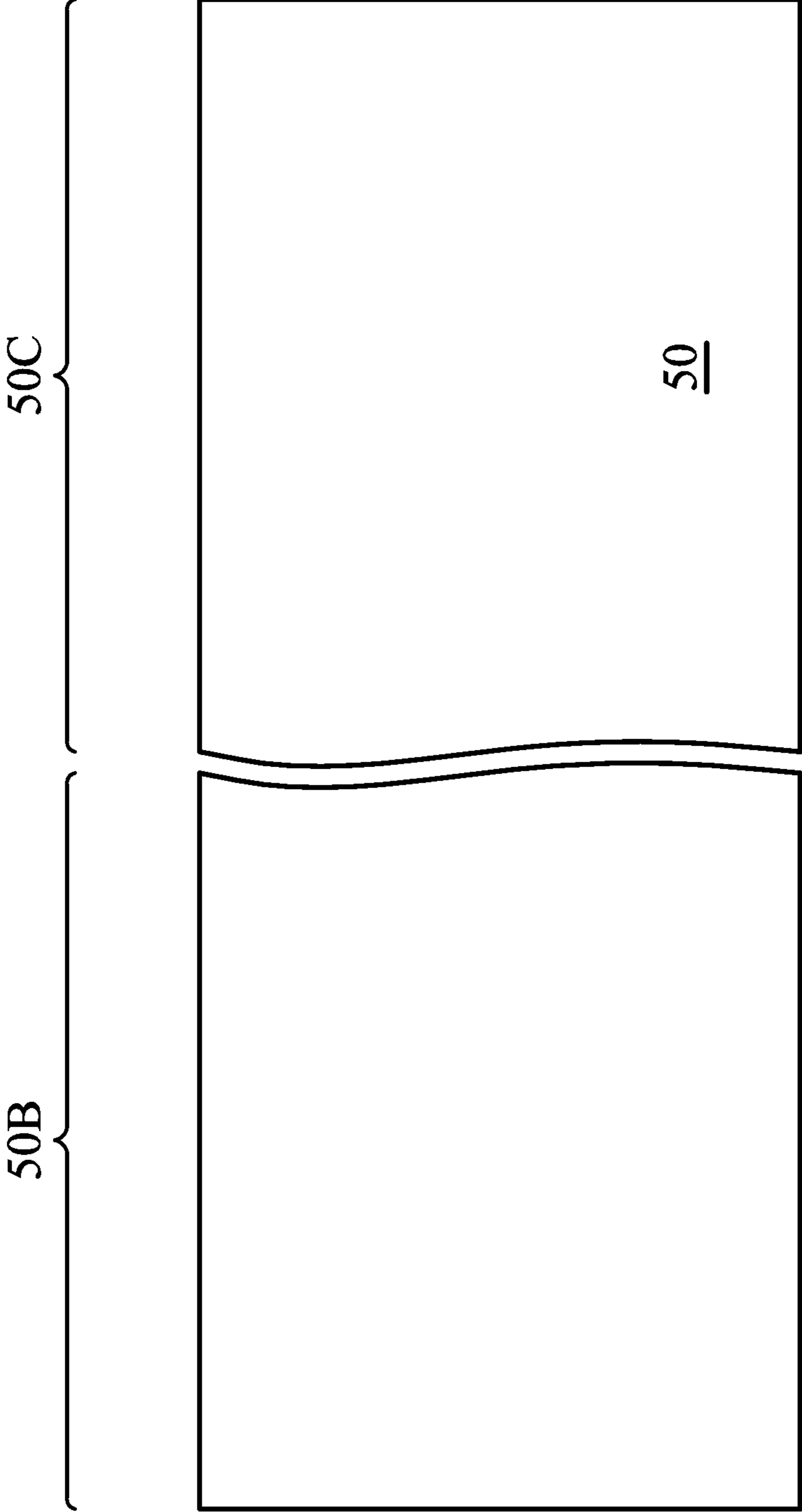


Figure 2

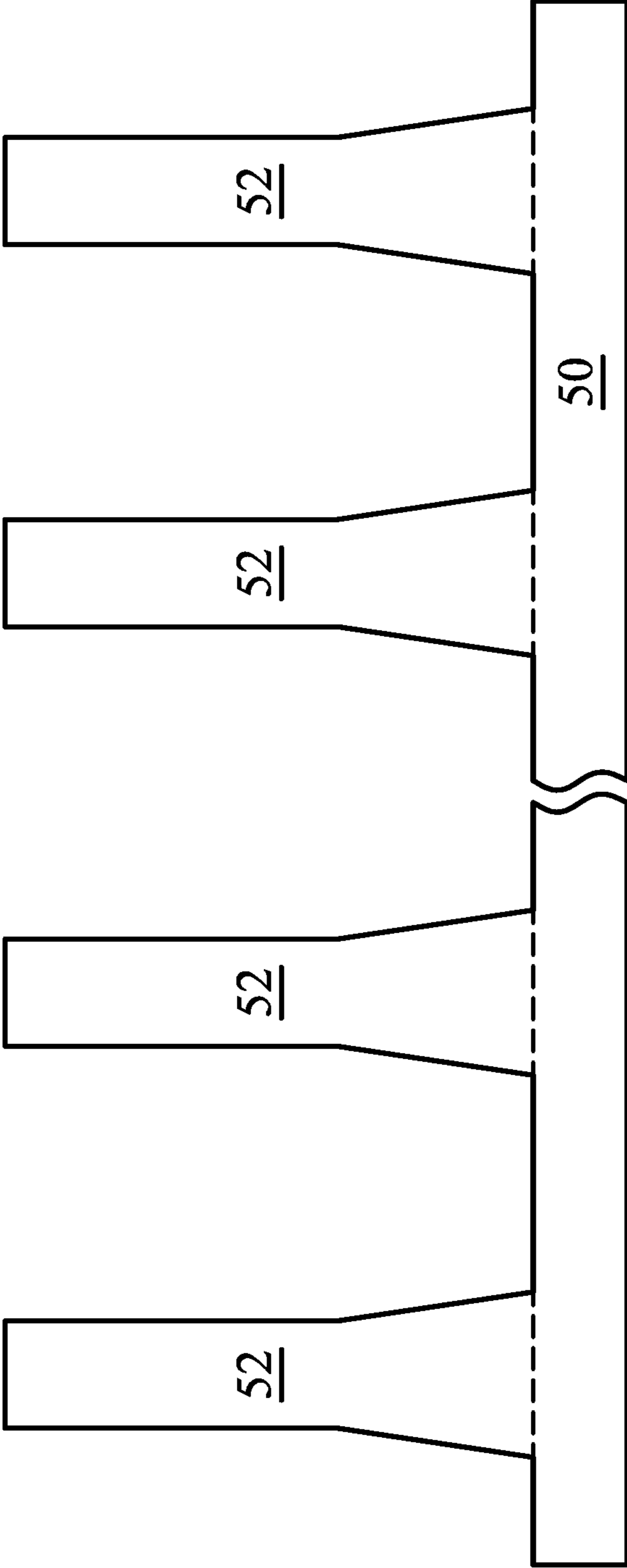


Figure 3

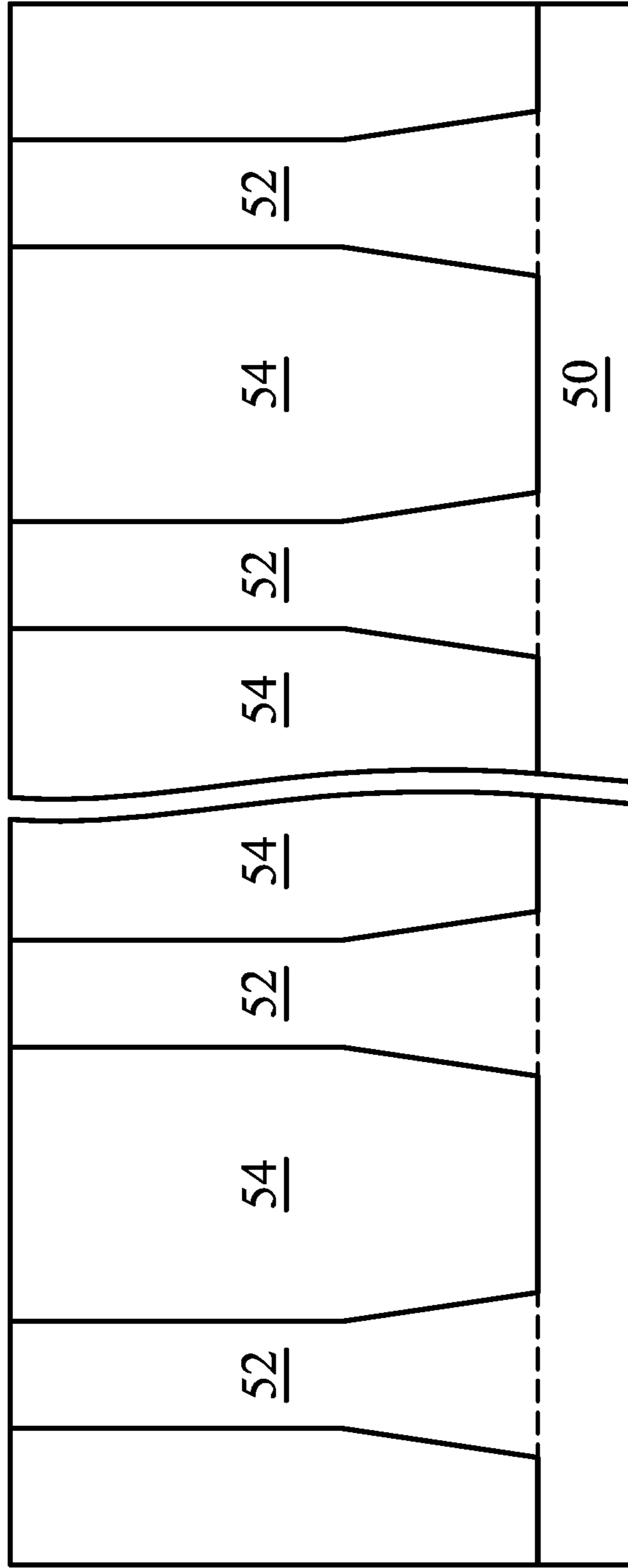


Figure 4

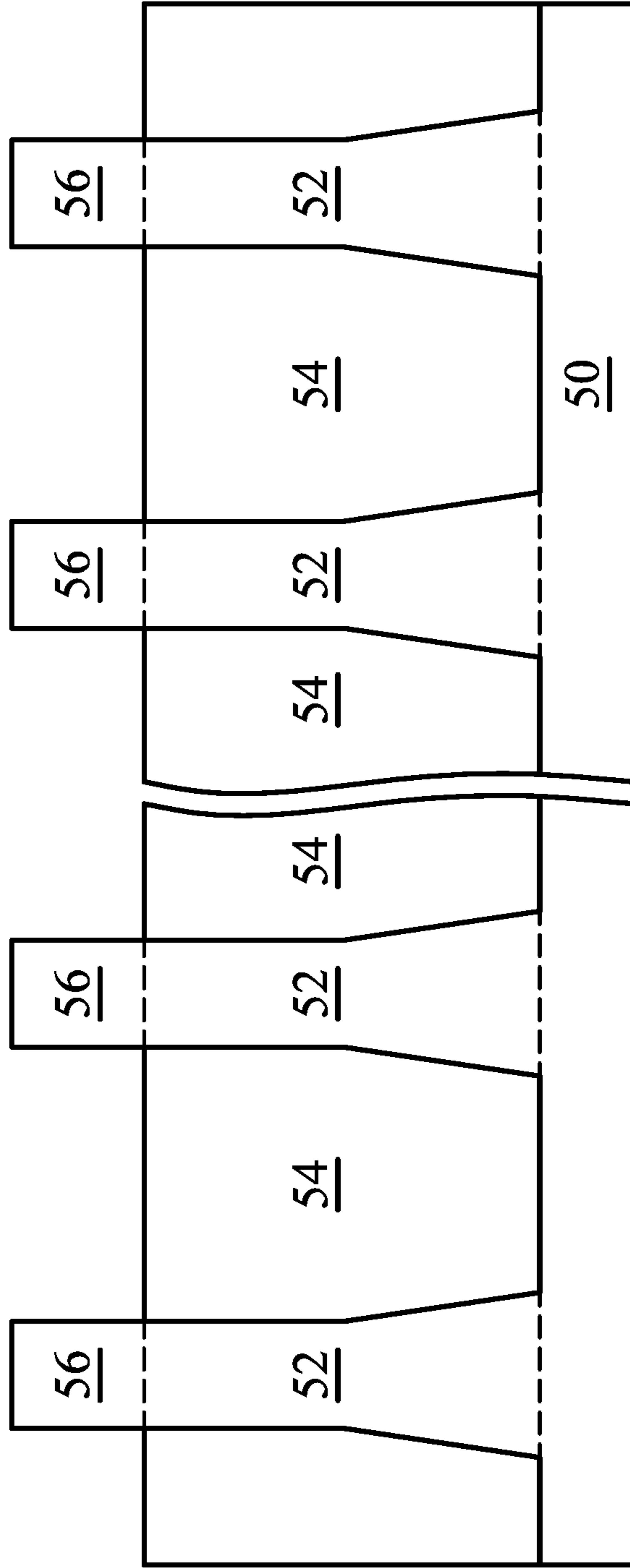


Figure 5

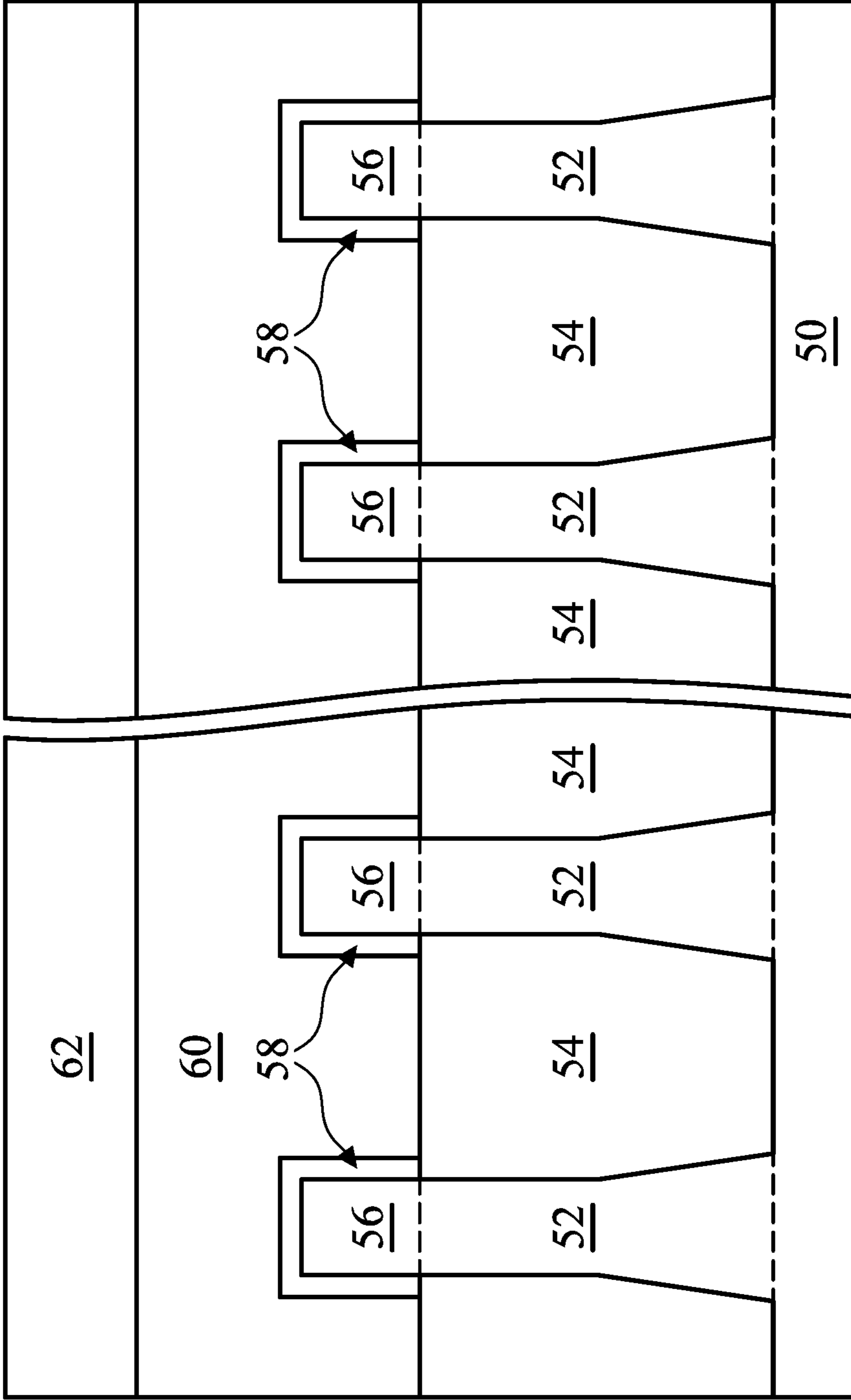


Figure 6



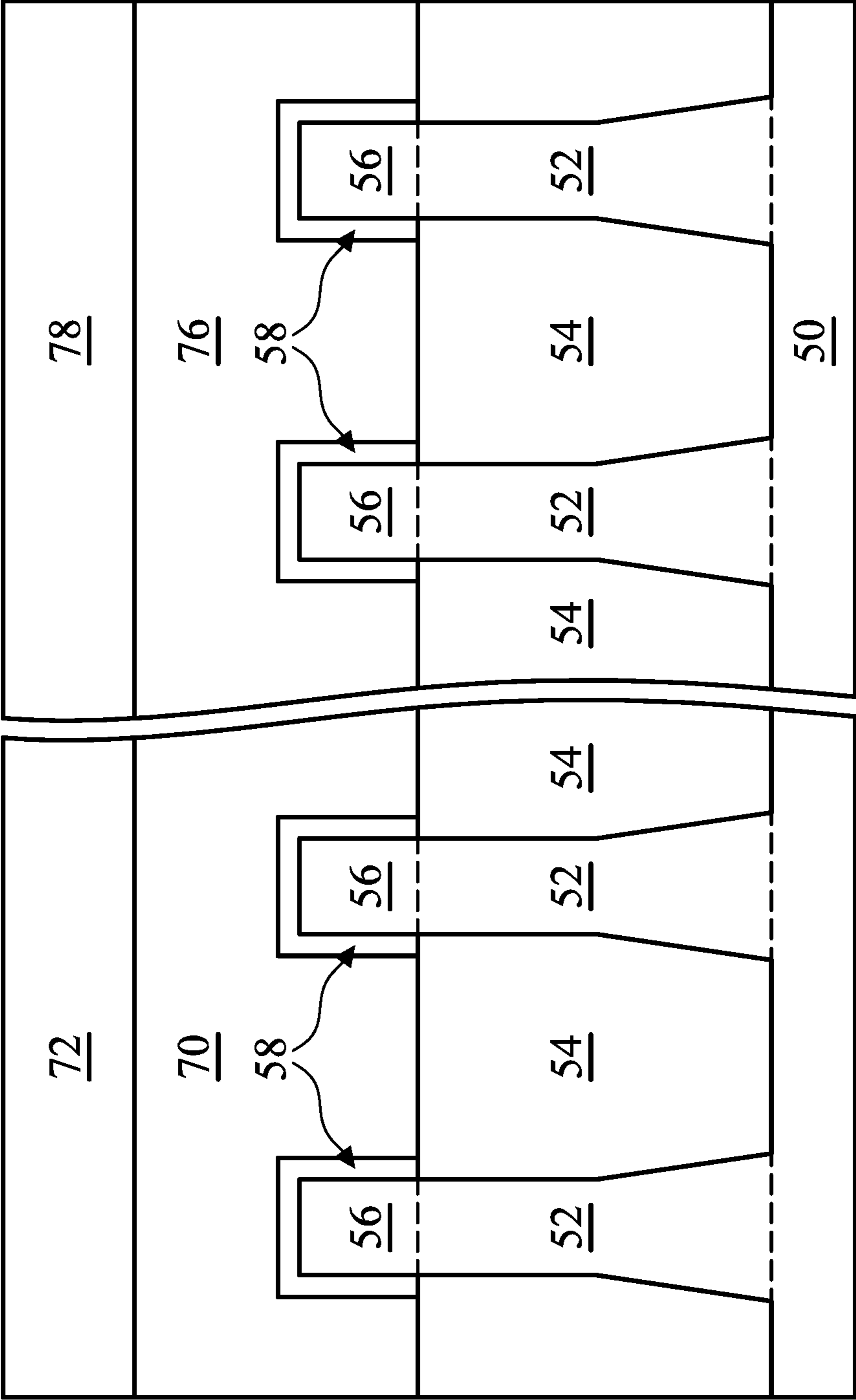


Figure 7A

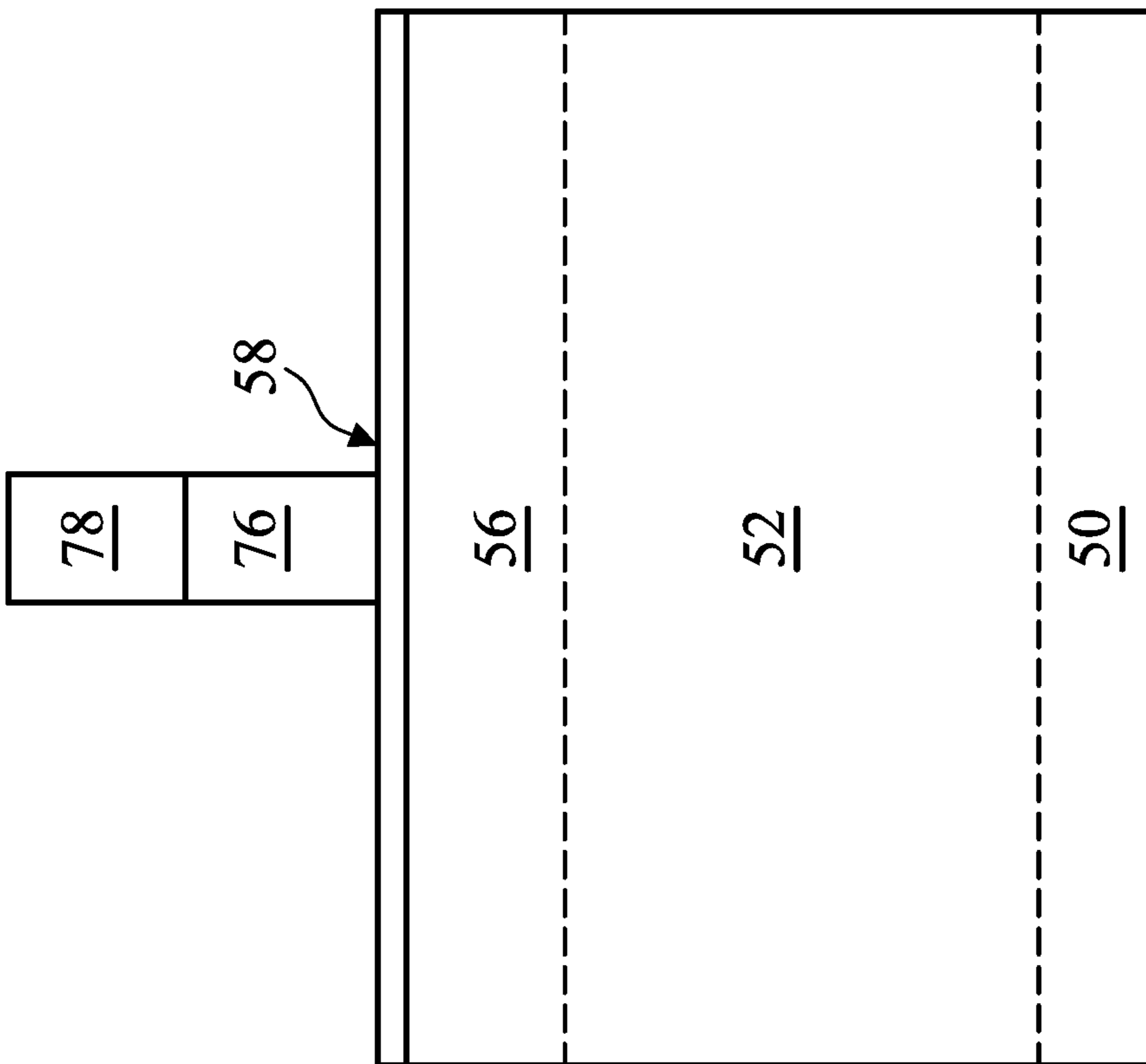


Figure 7C

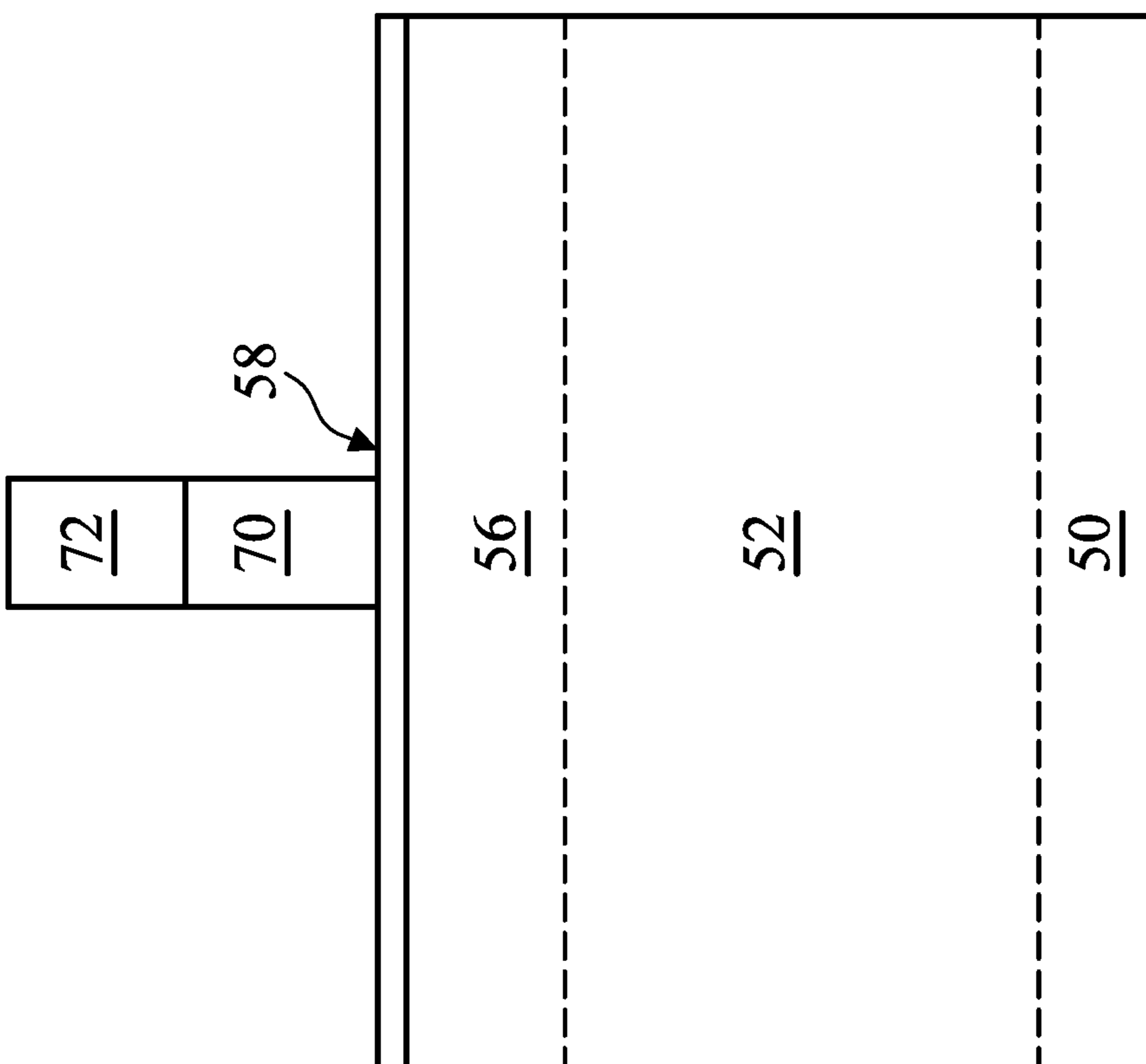


Figure 7B

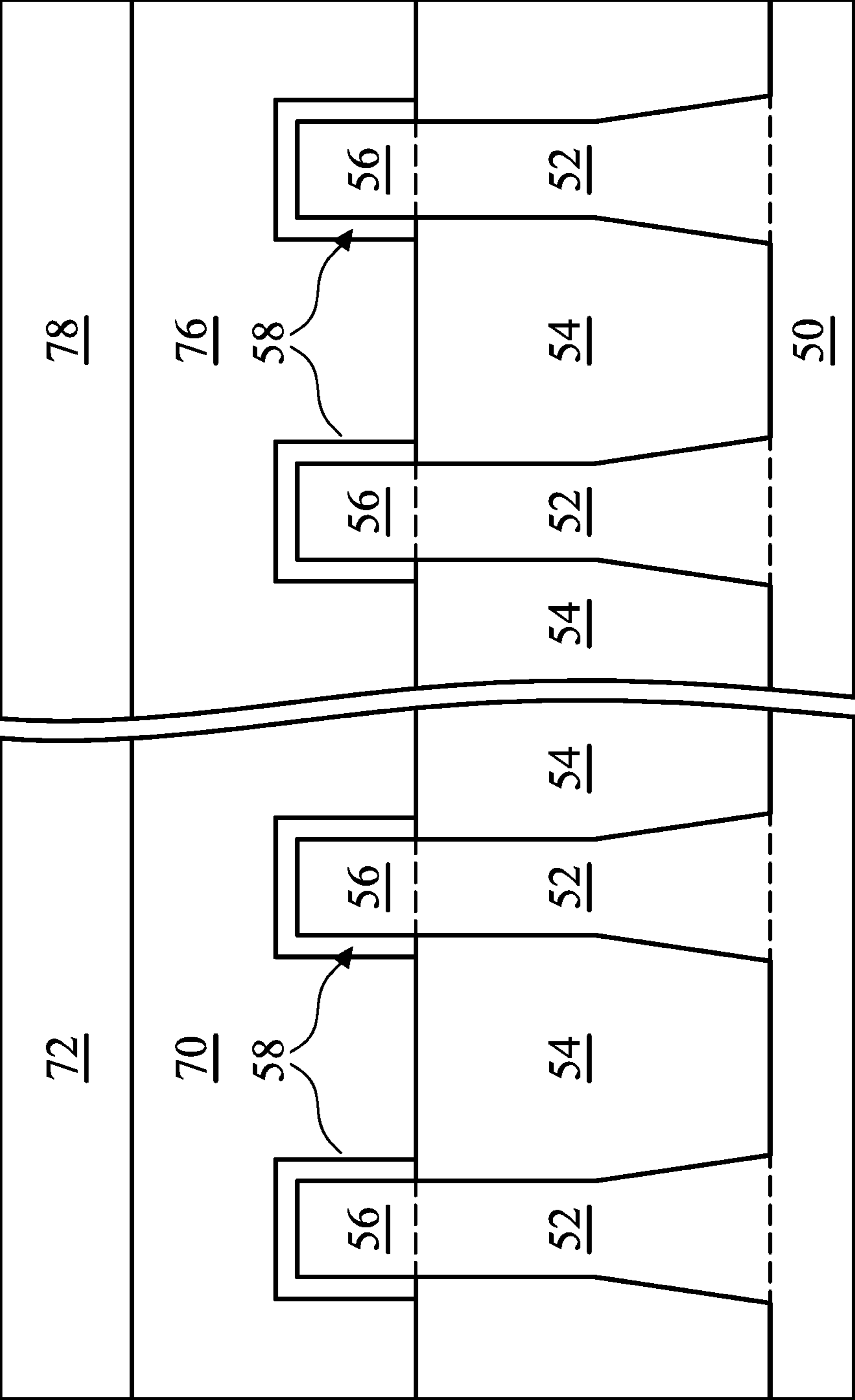


Figure 8A

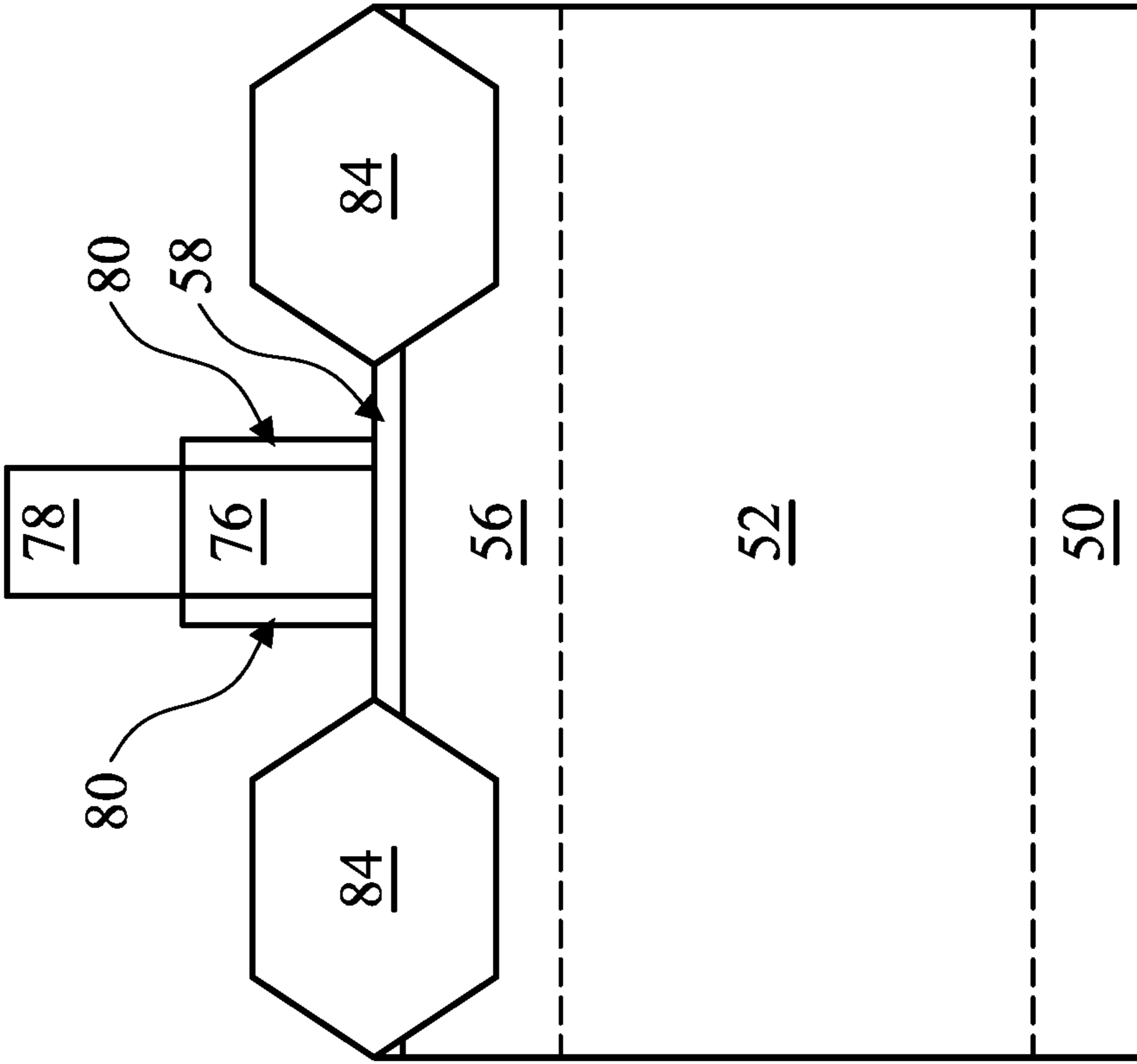


Figure 8C

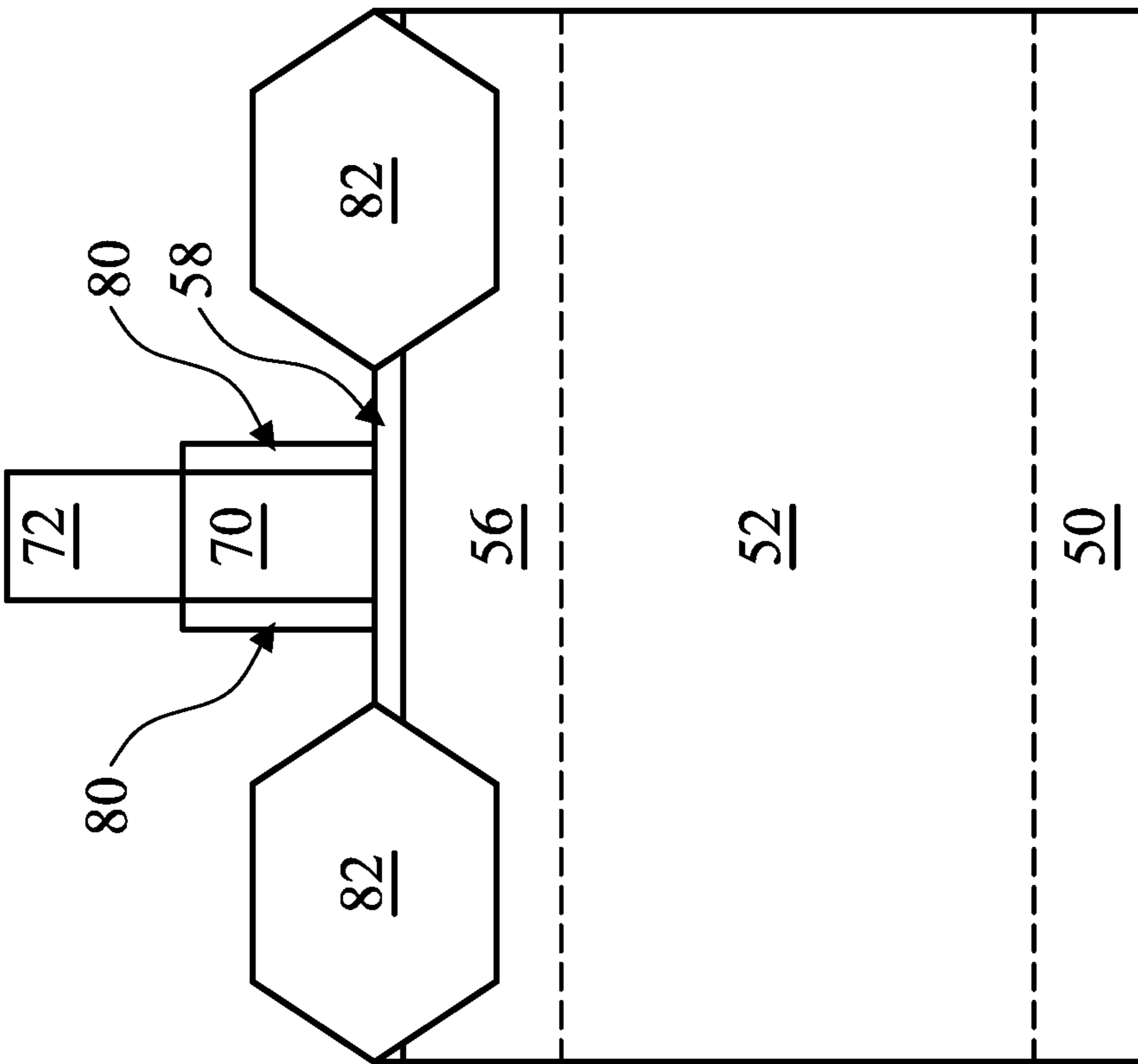


Figure 8B

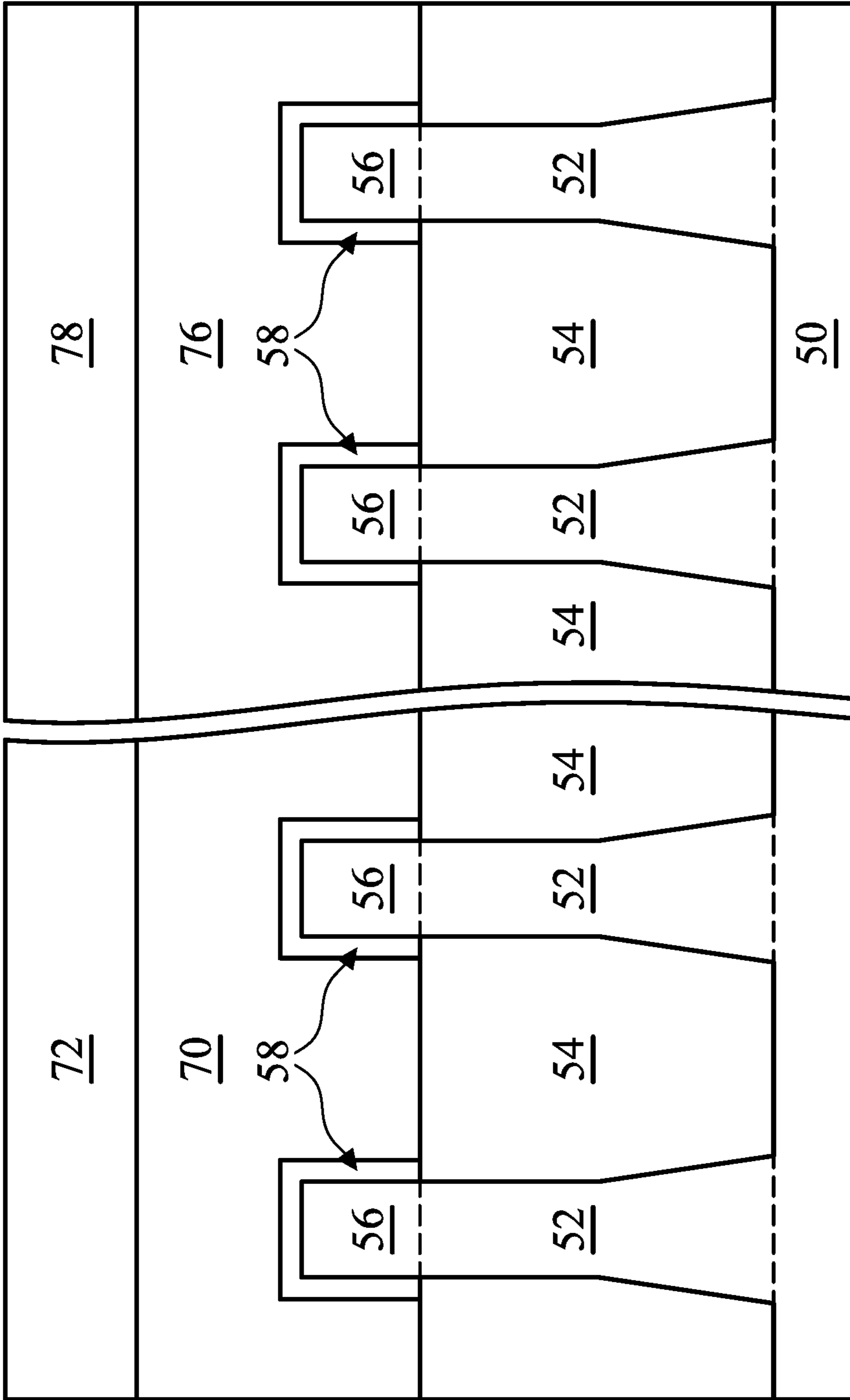


Figure 9A

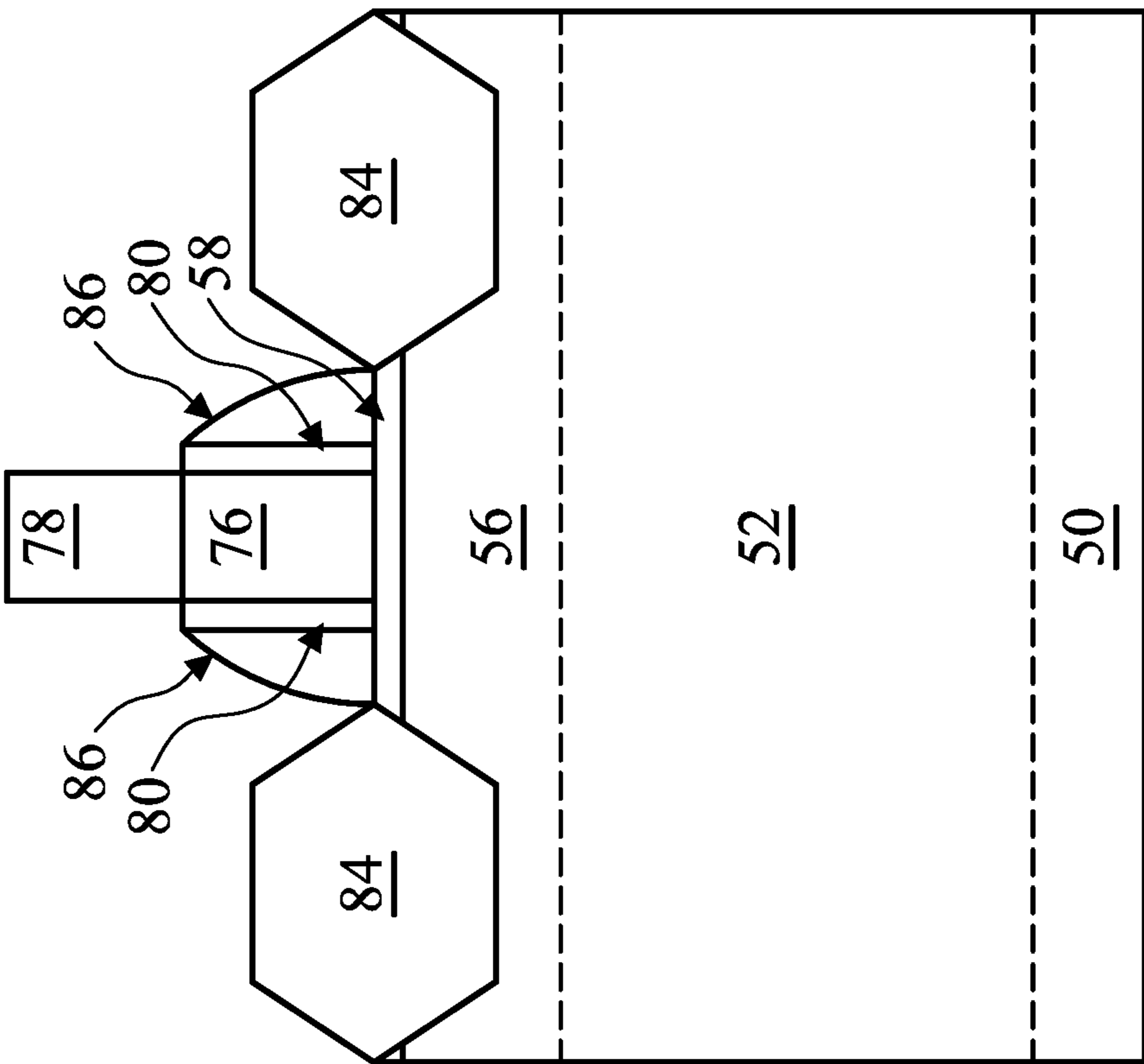


Figure 9C

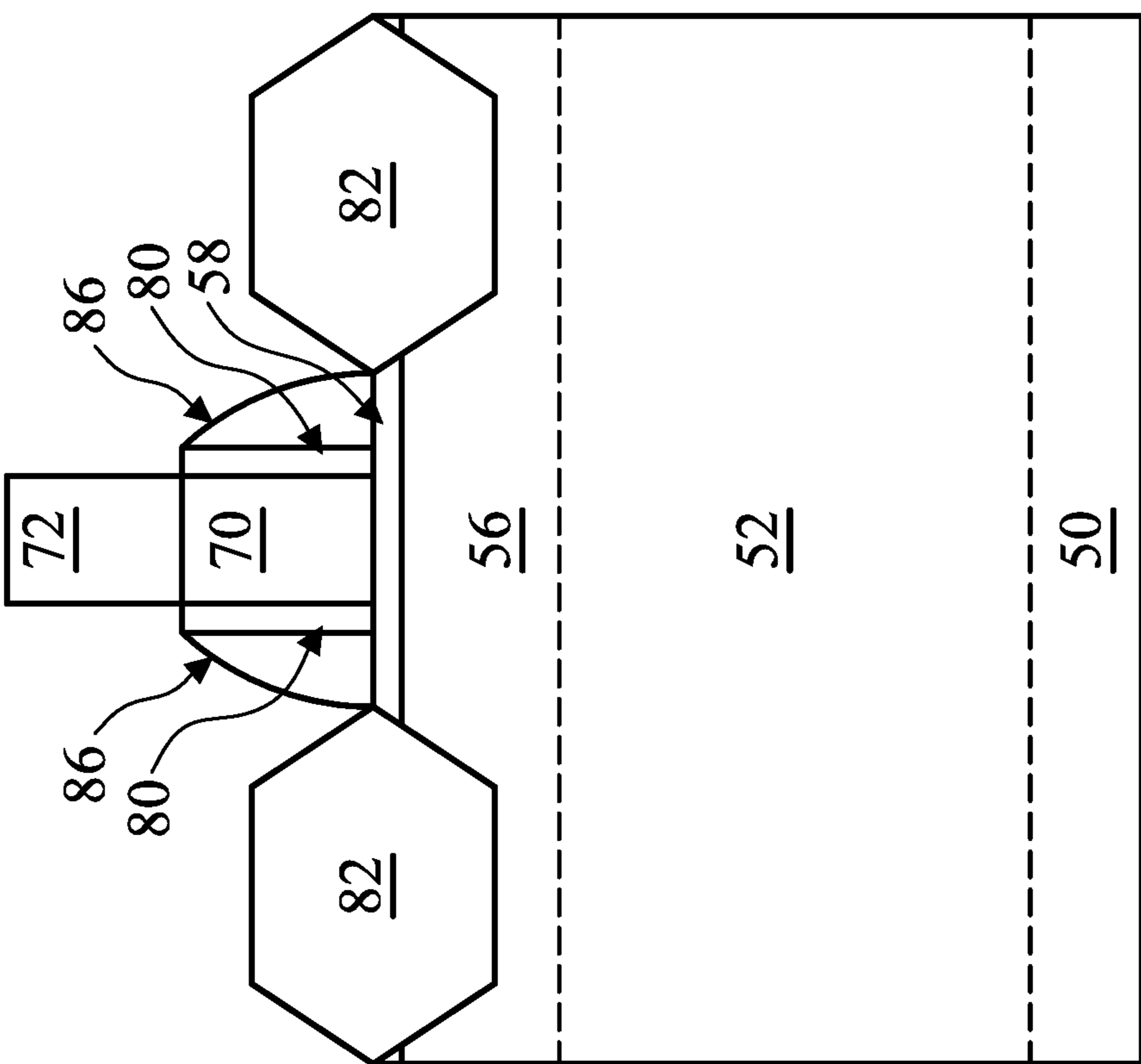


Figure 9B

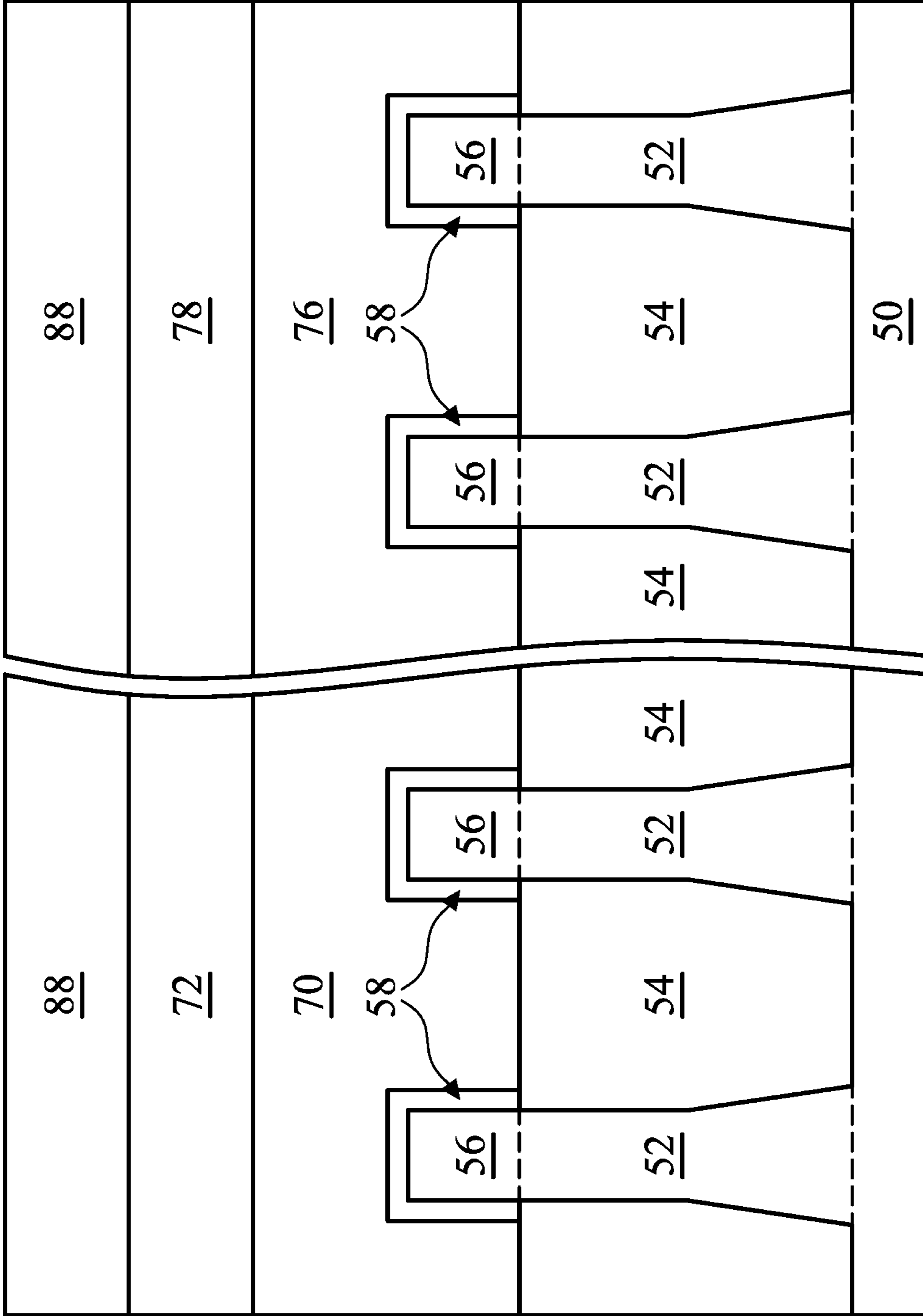


Figure 10A

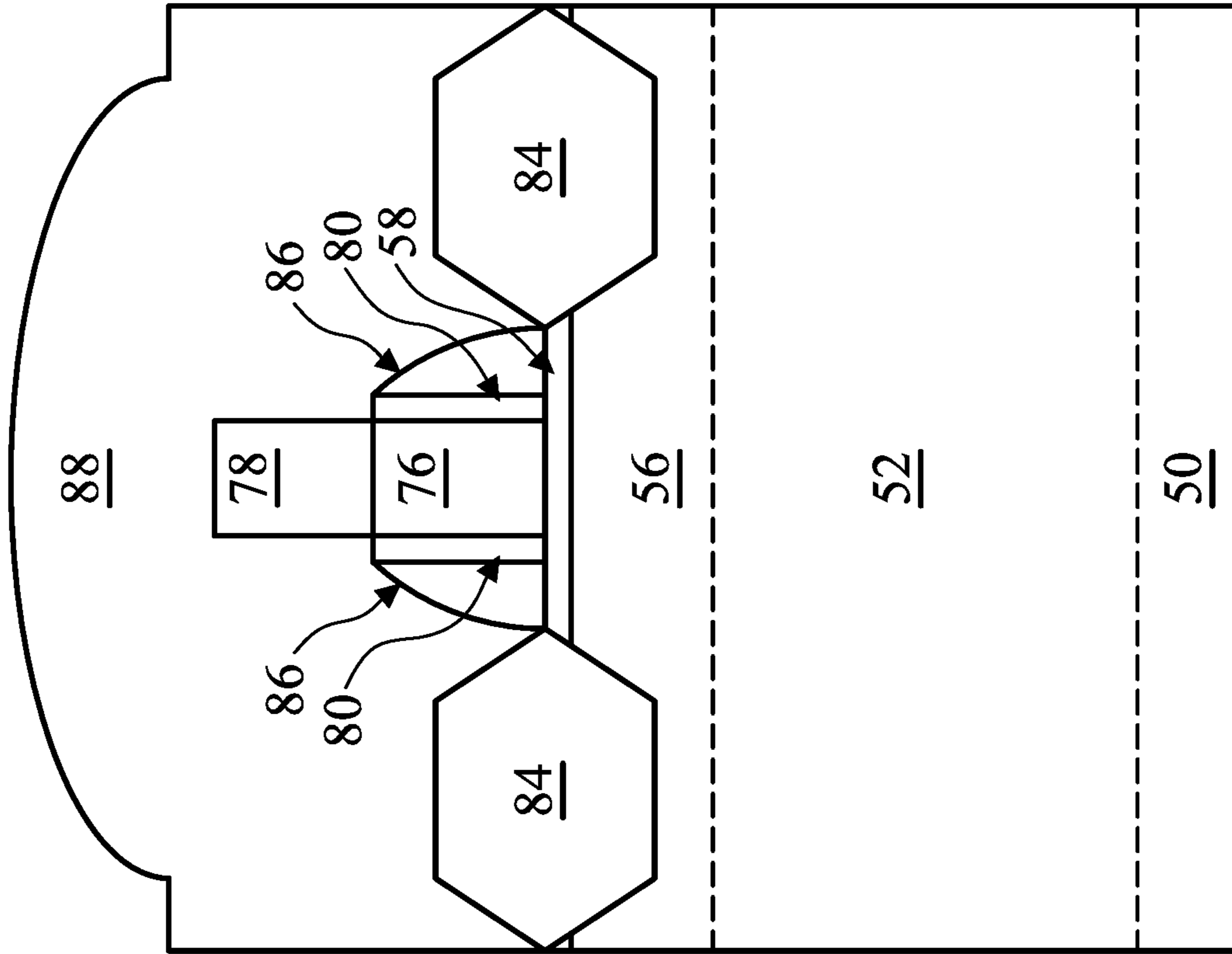


Figure 10C

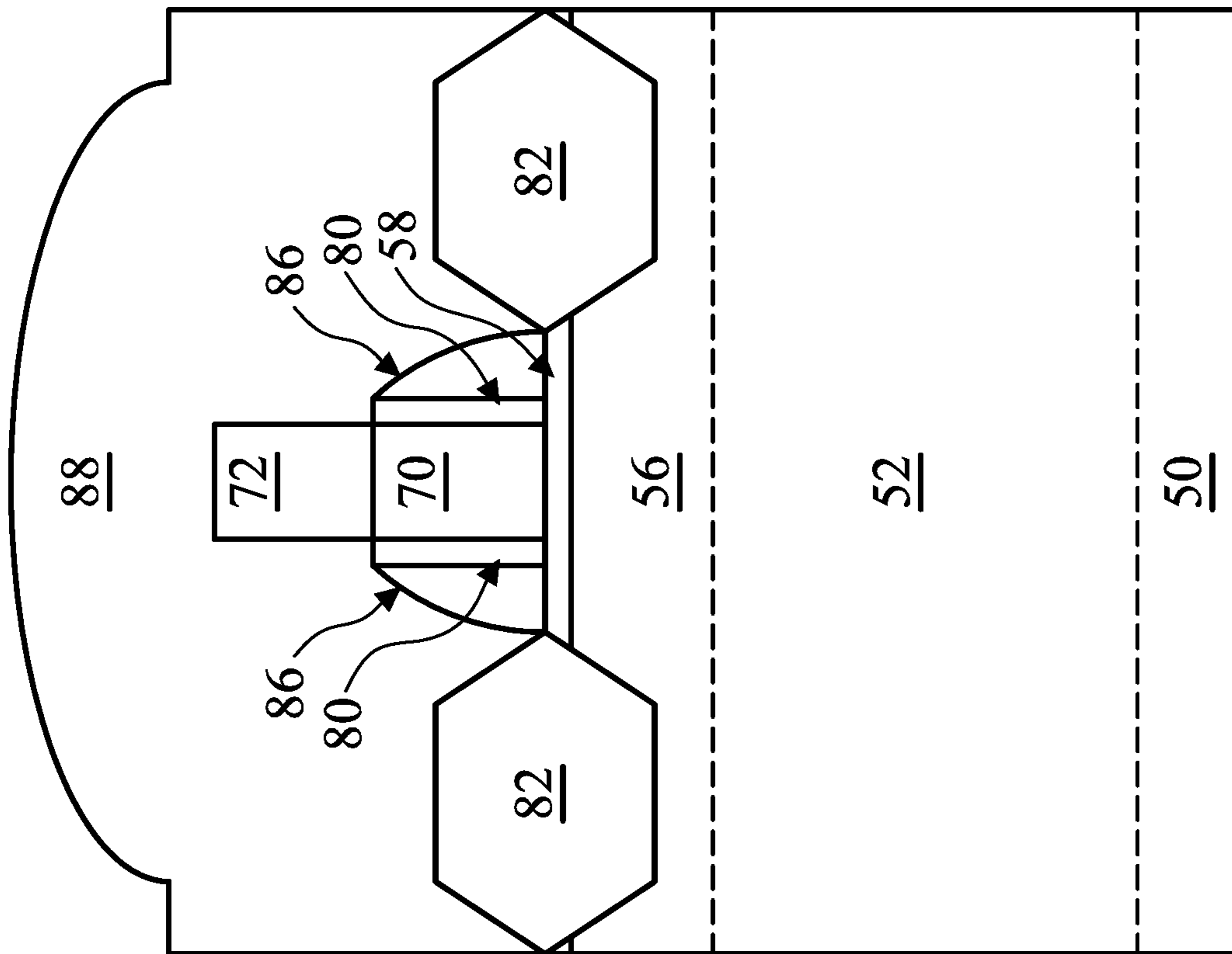


Figure 10B



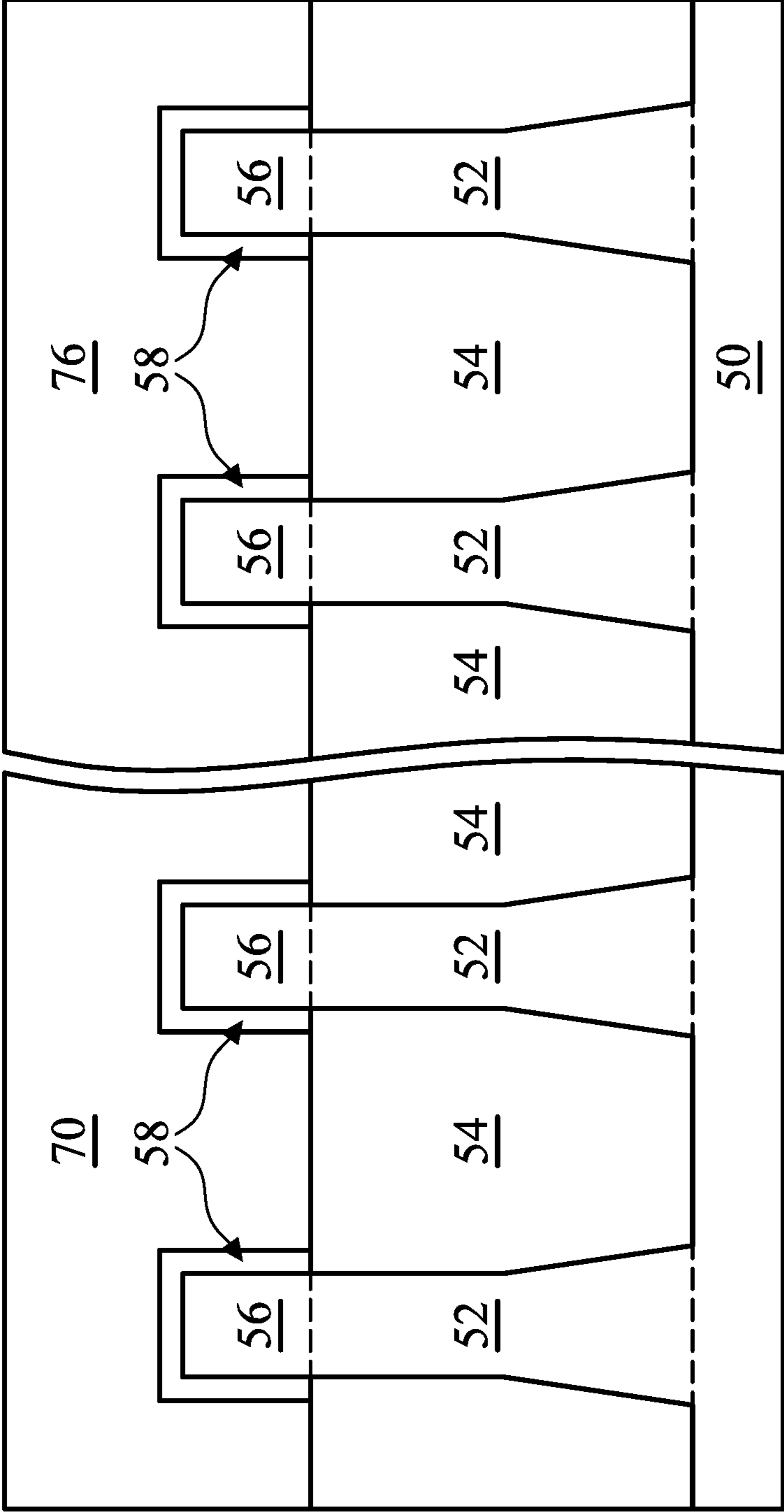


Figure 11A

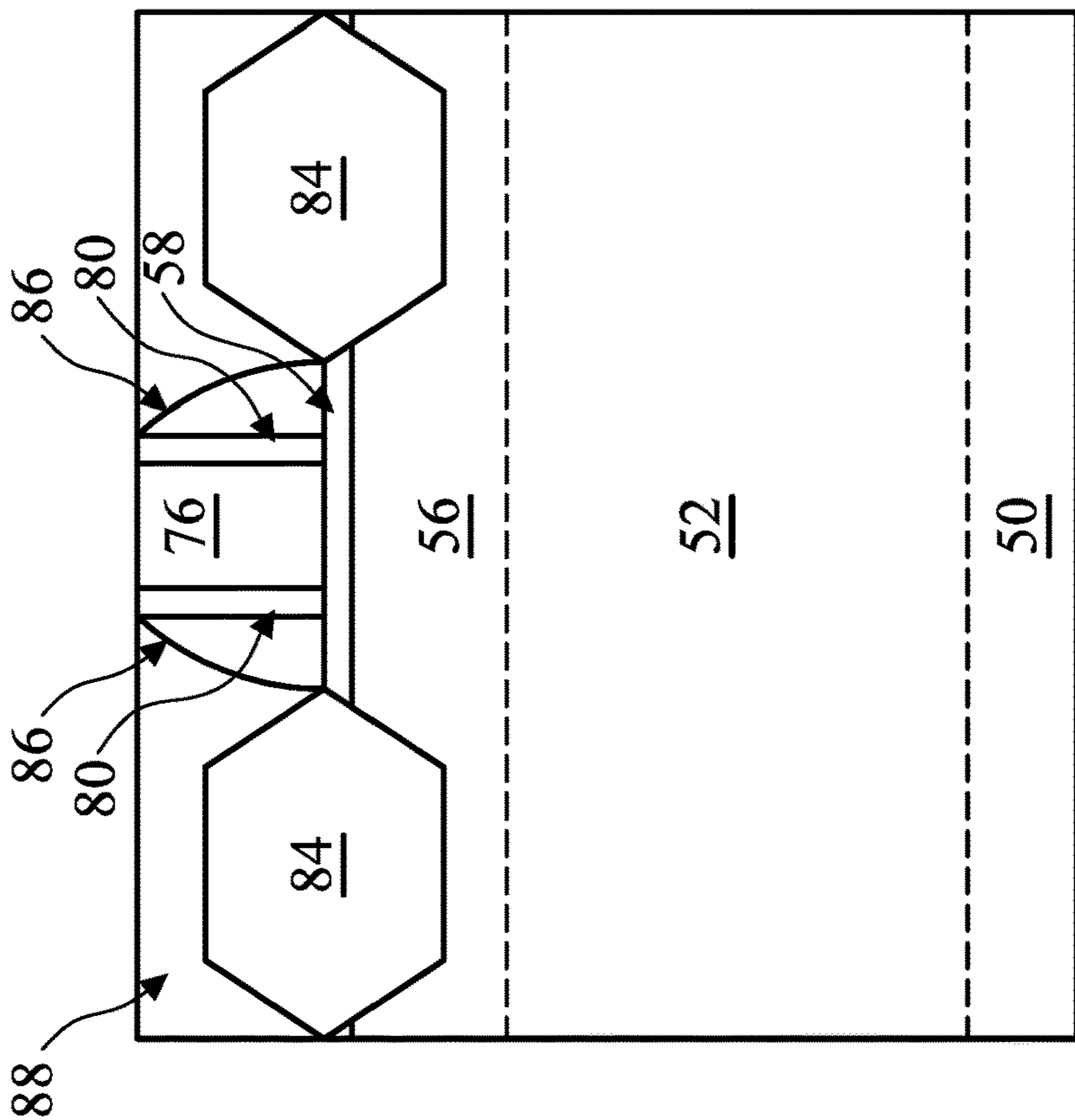


Figure 11B

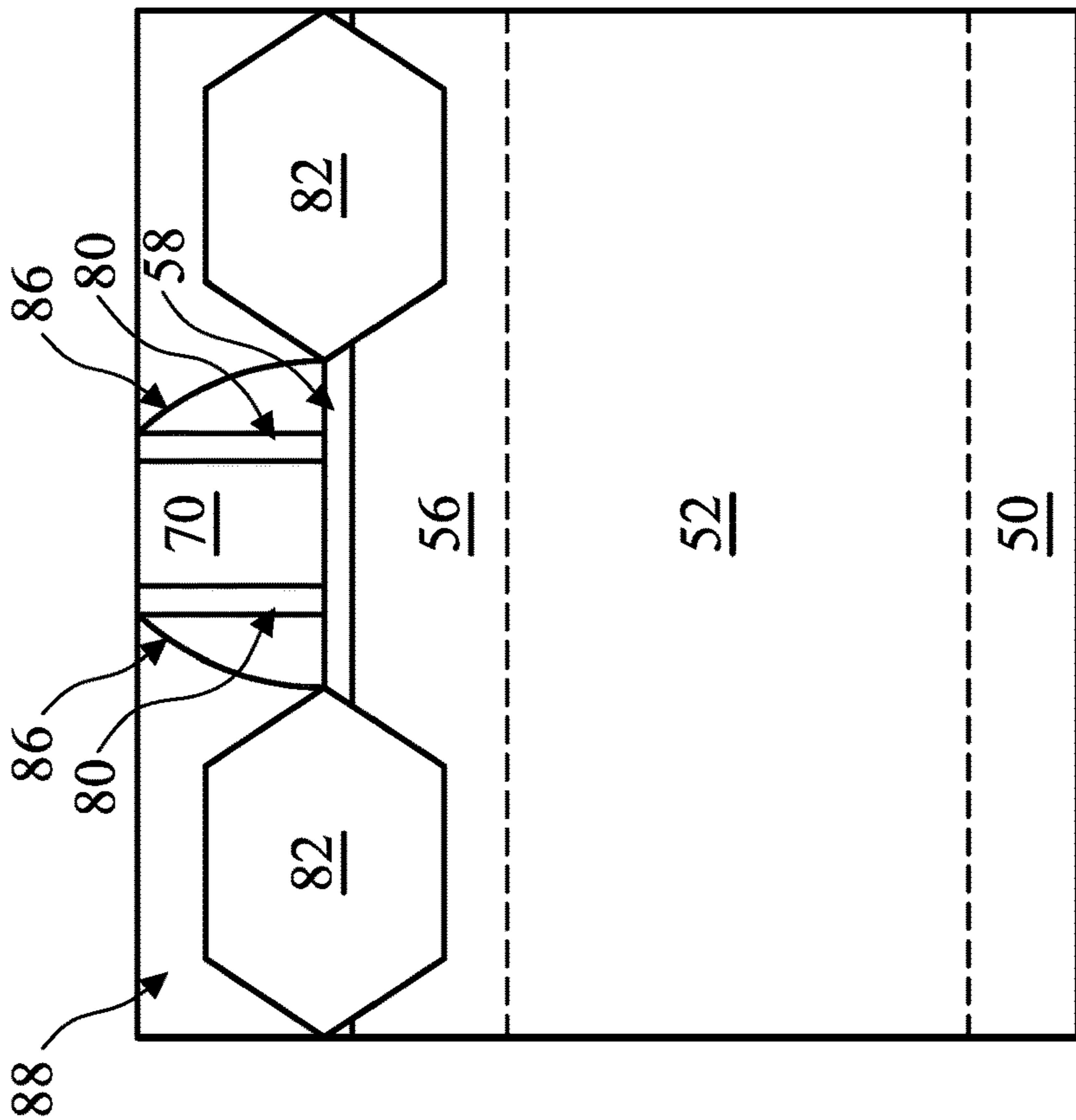


Figure 11C

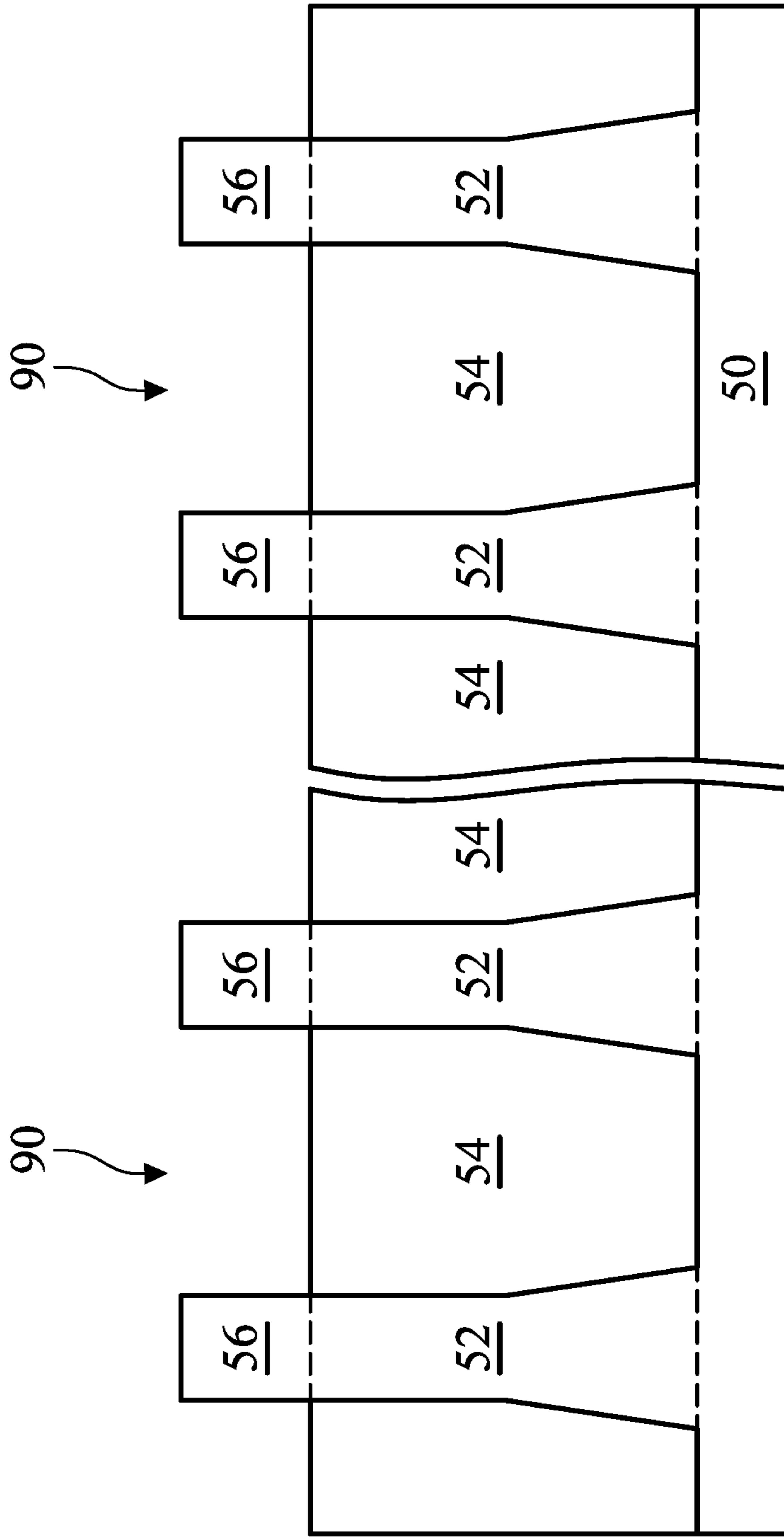


Figure 12A

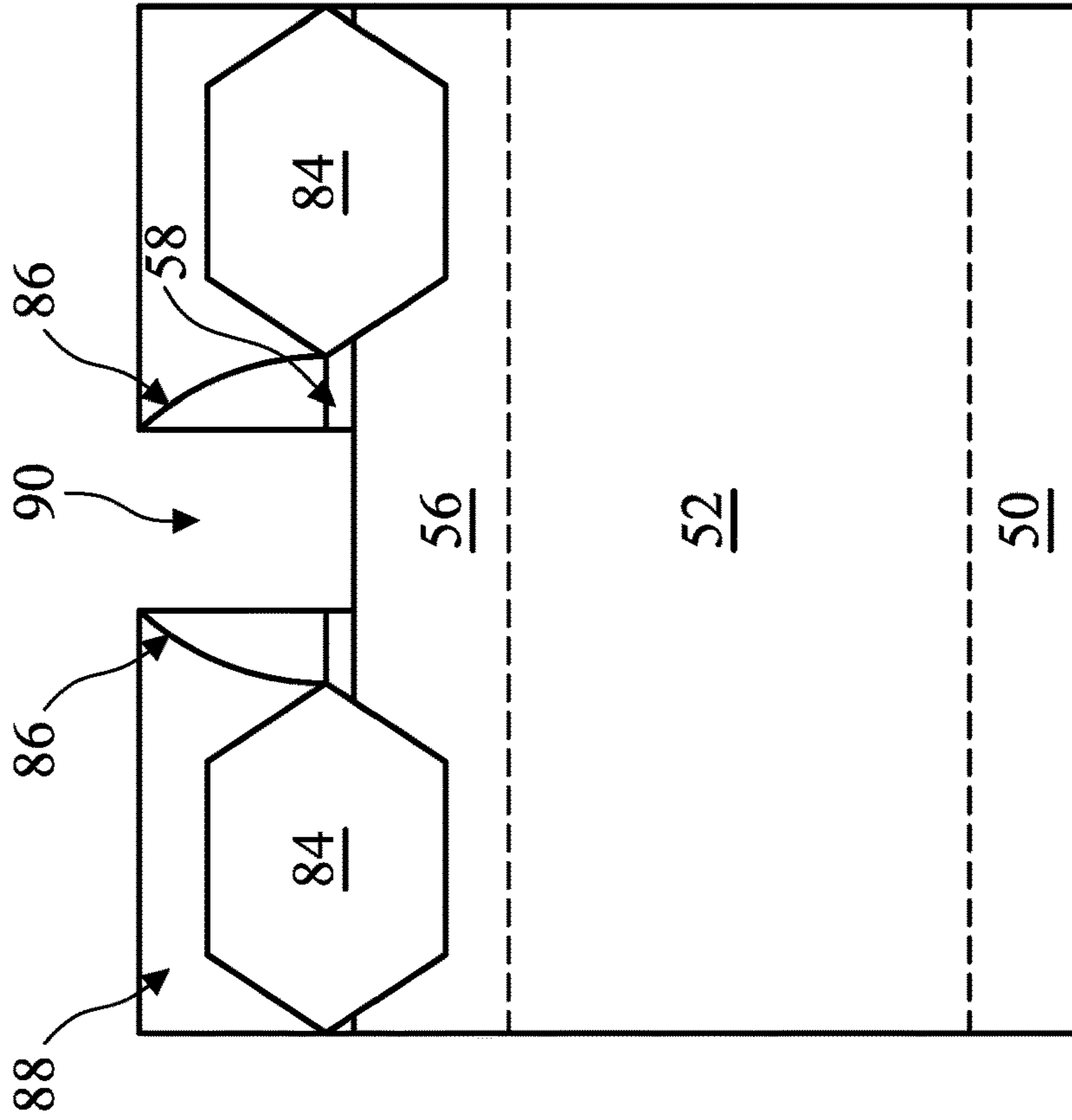


Figure 12B

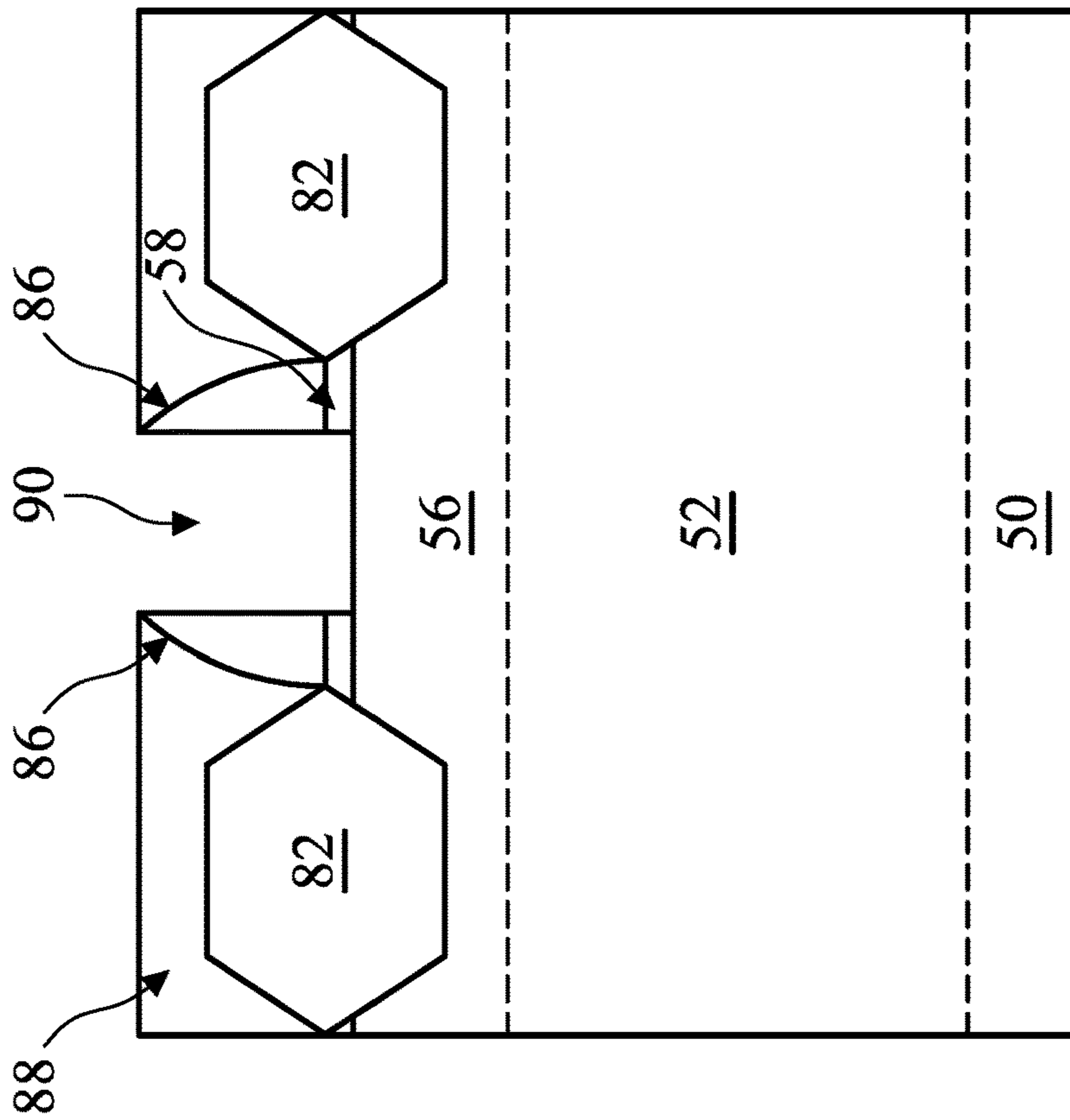


Figure 12C

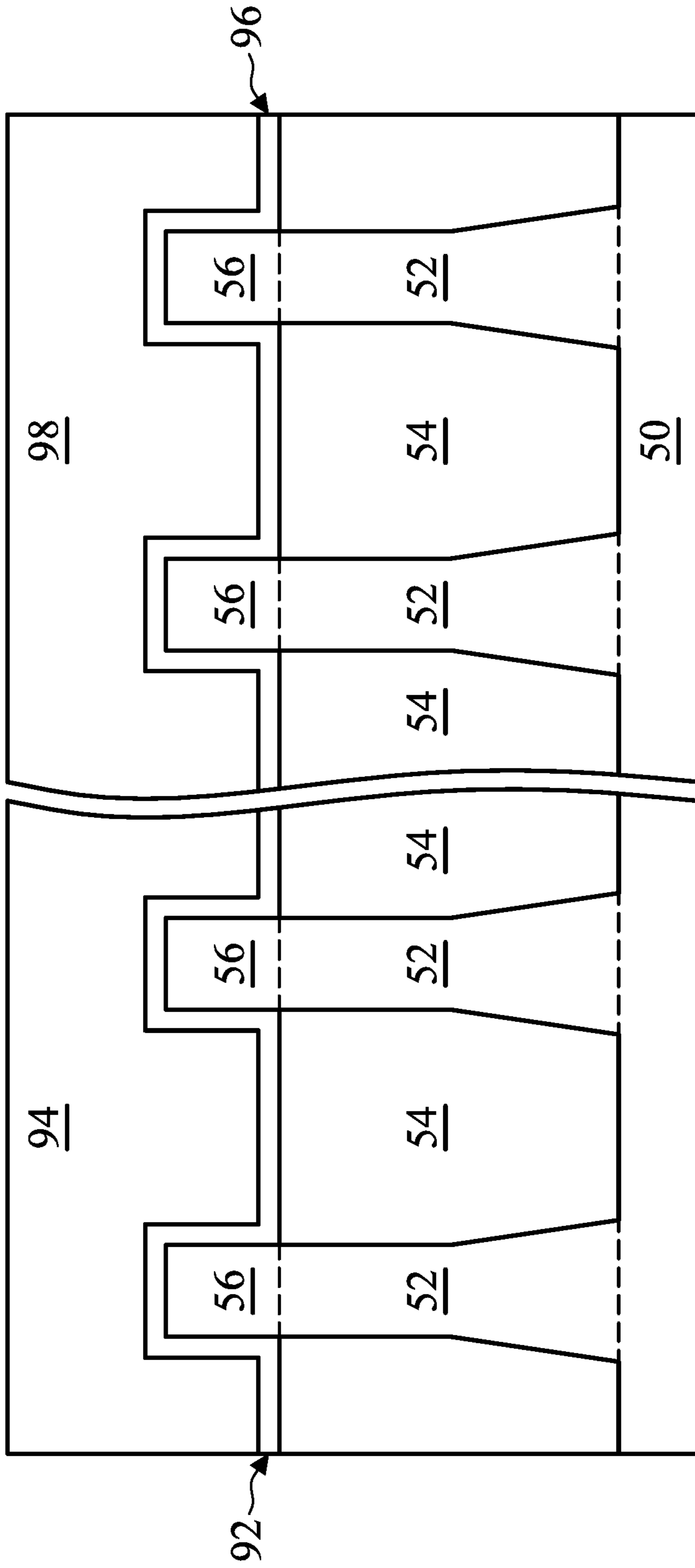


Figure 13A

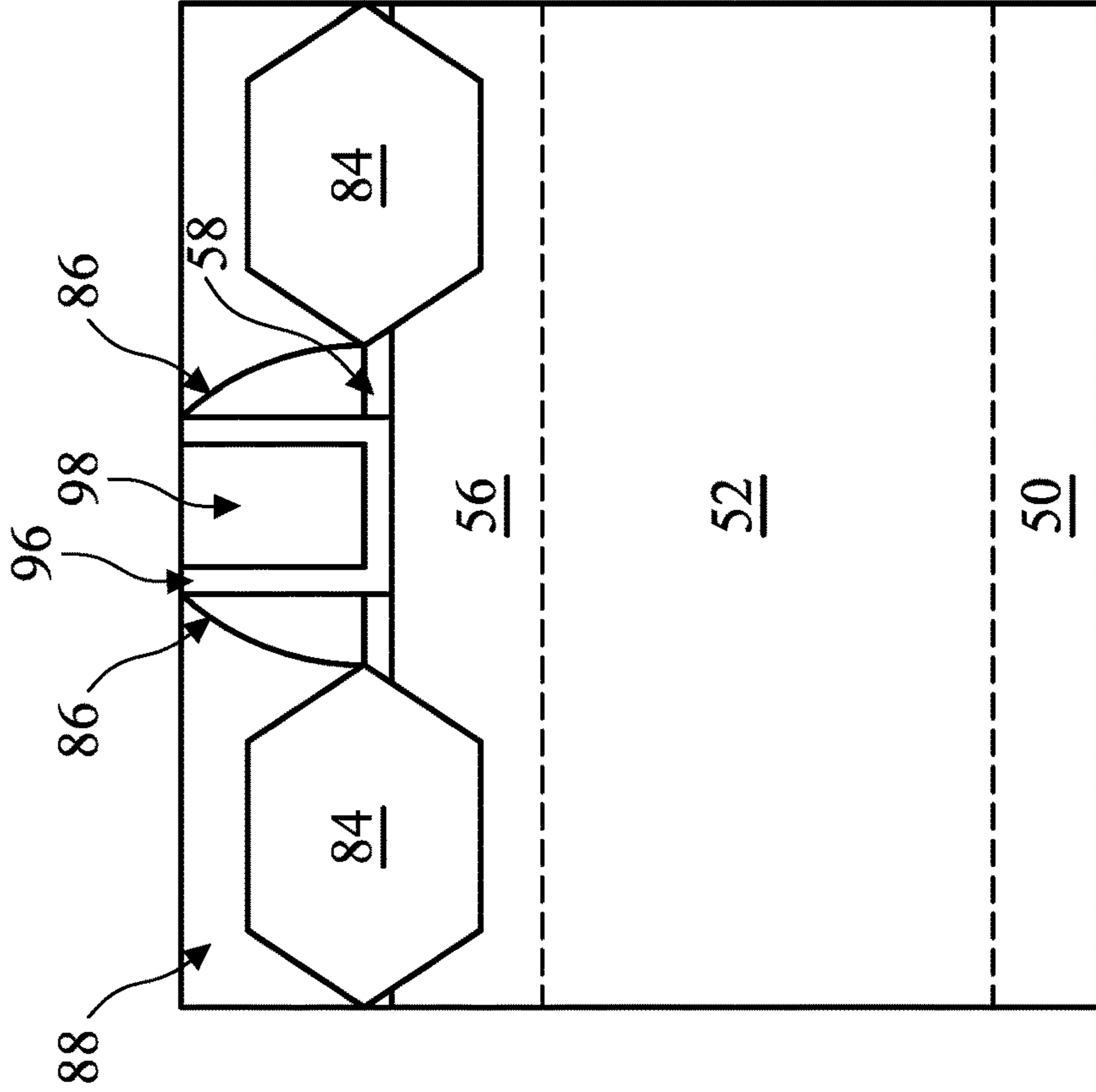


Figure 13B

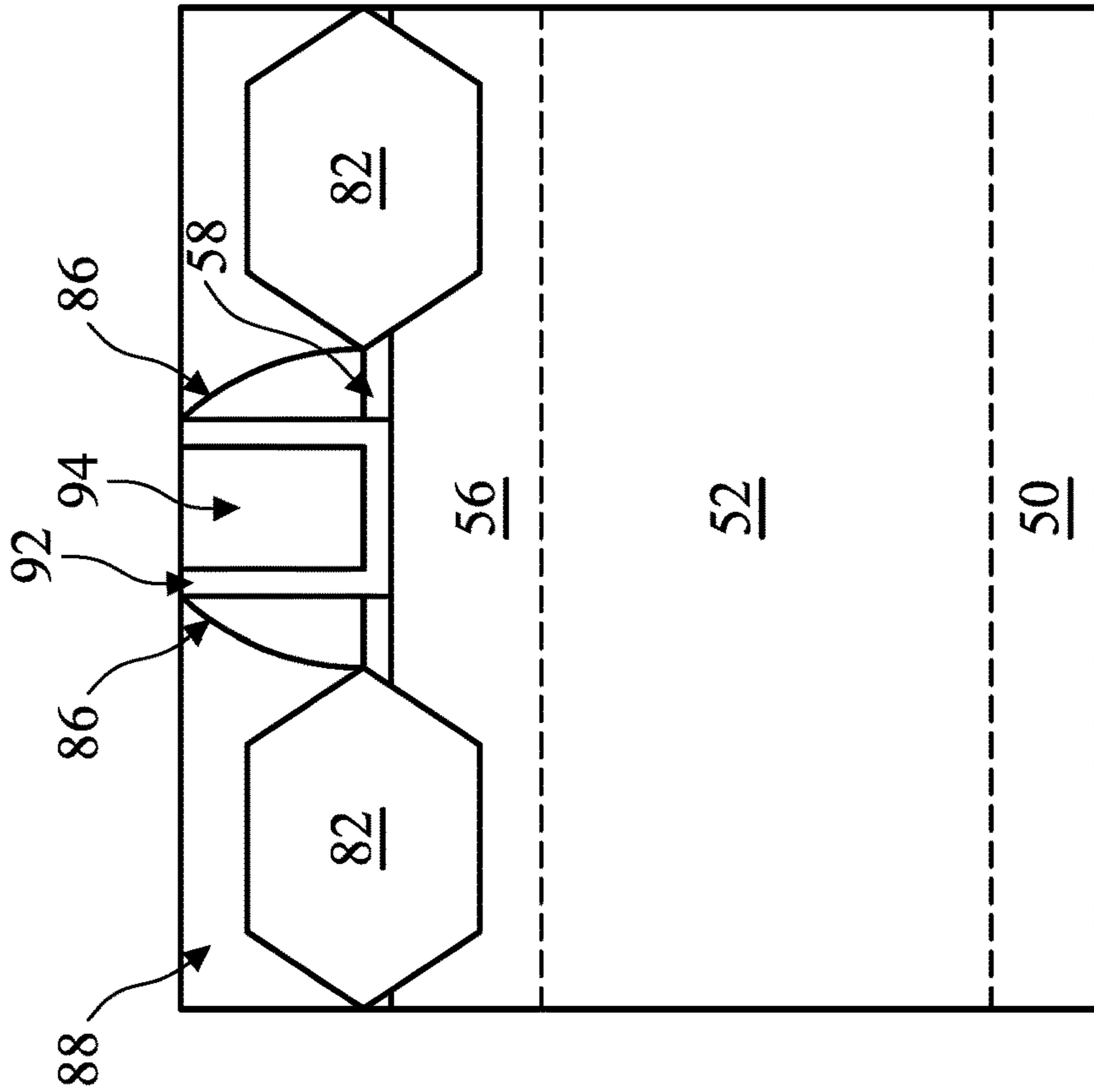


Figure 13C

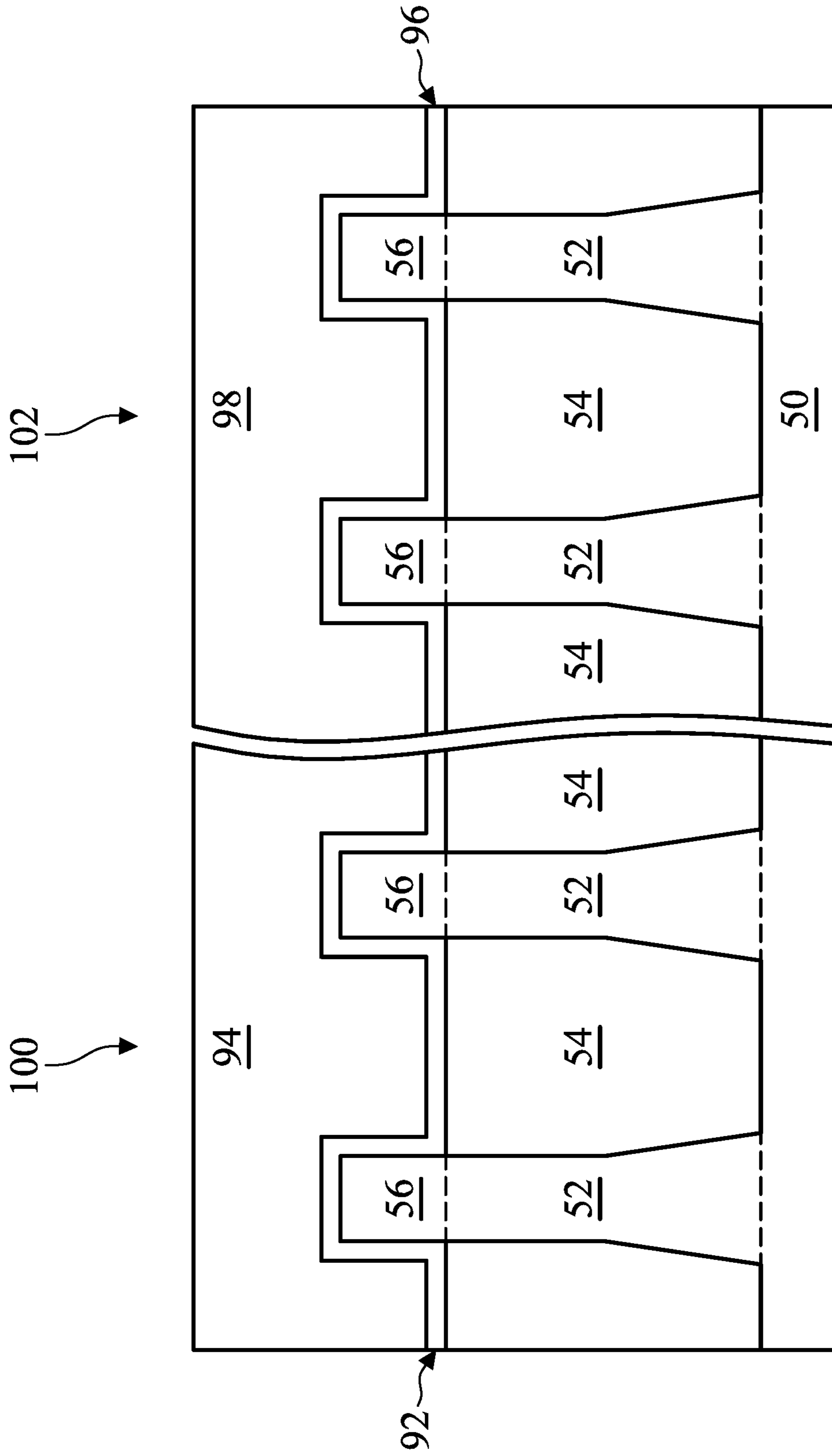


Figure 14A

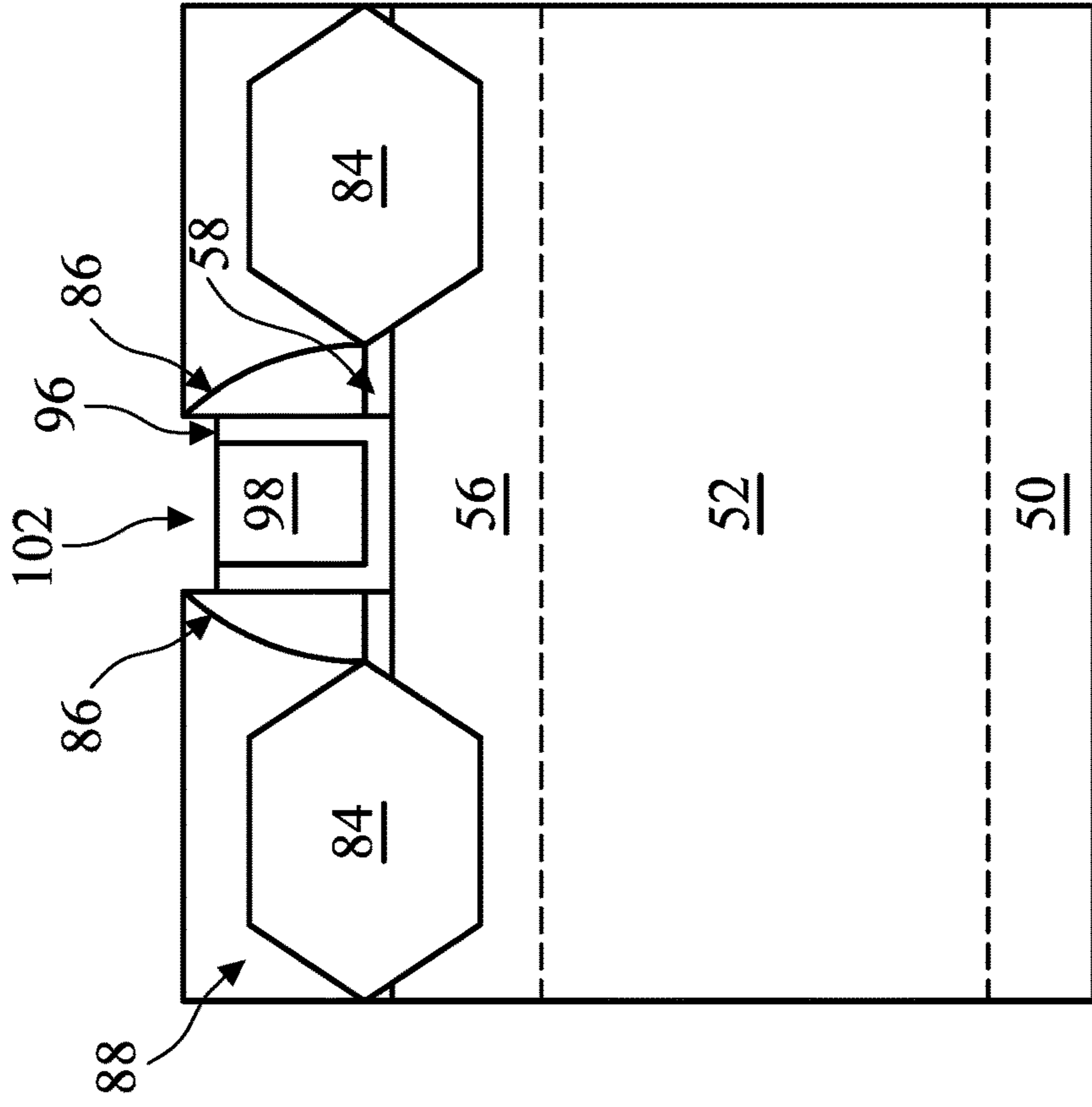


Figure 14B

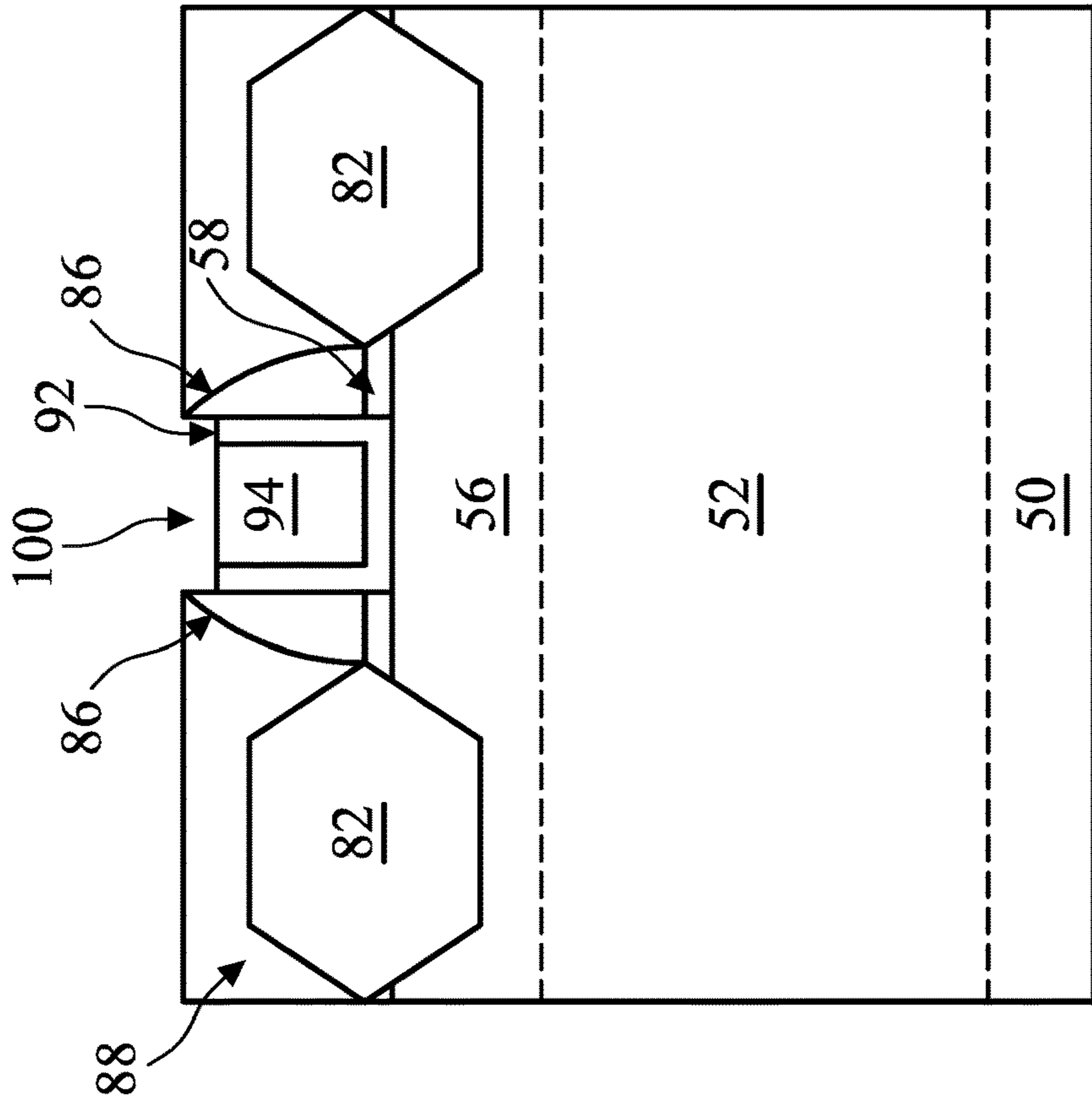


Figure 14C



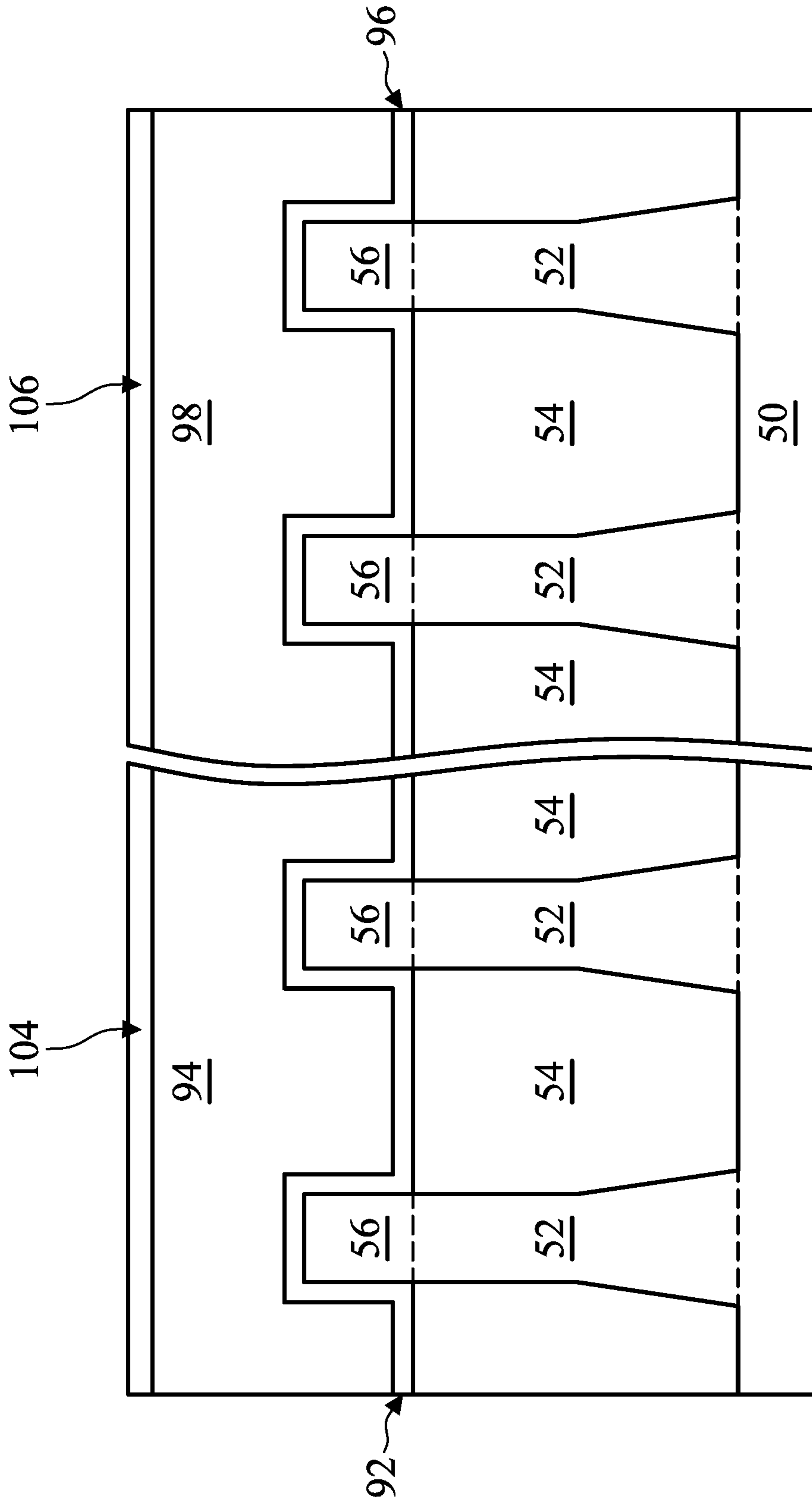


Figure 15A

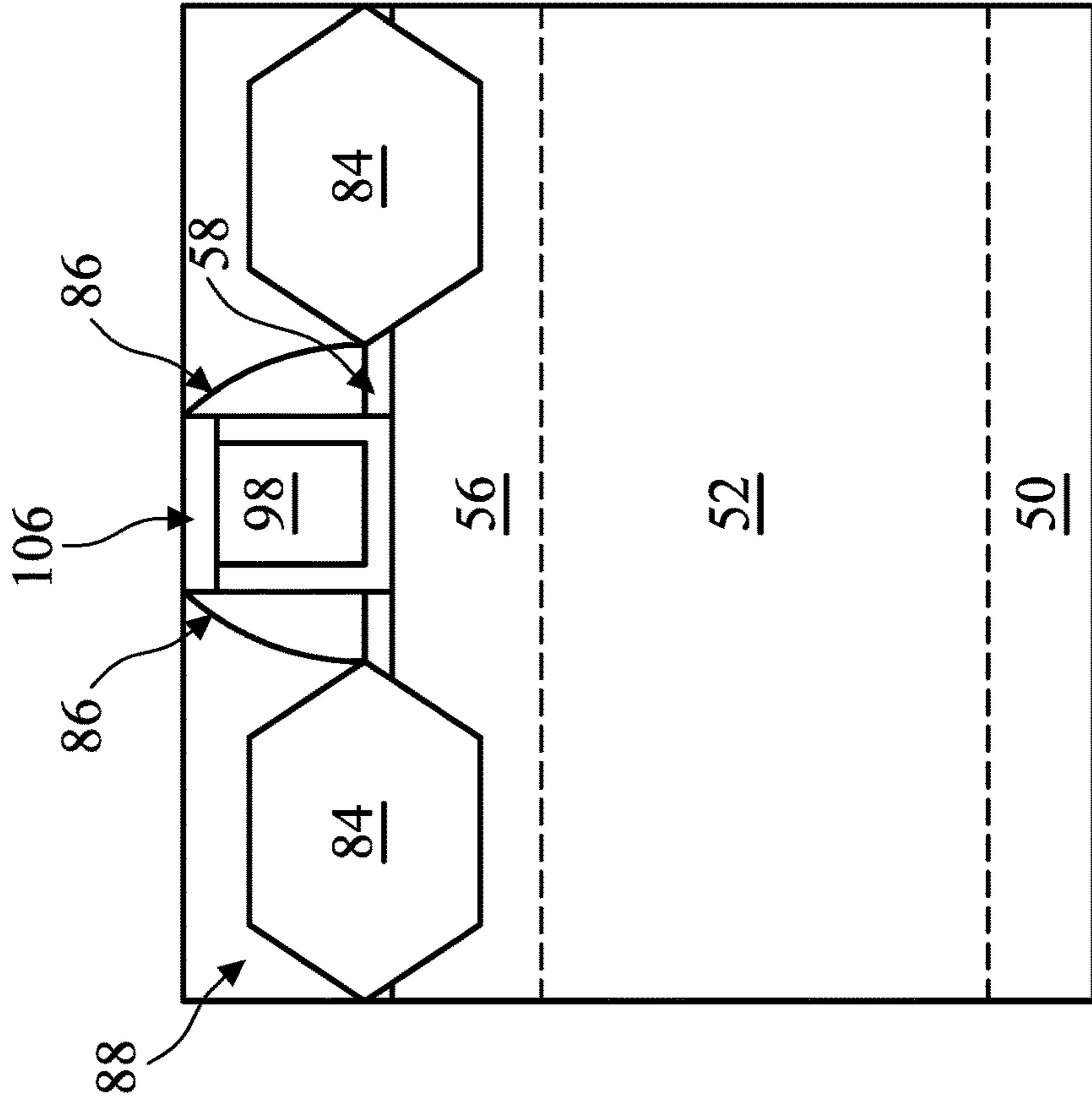


Figure 15B

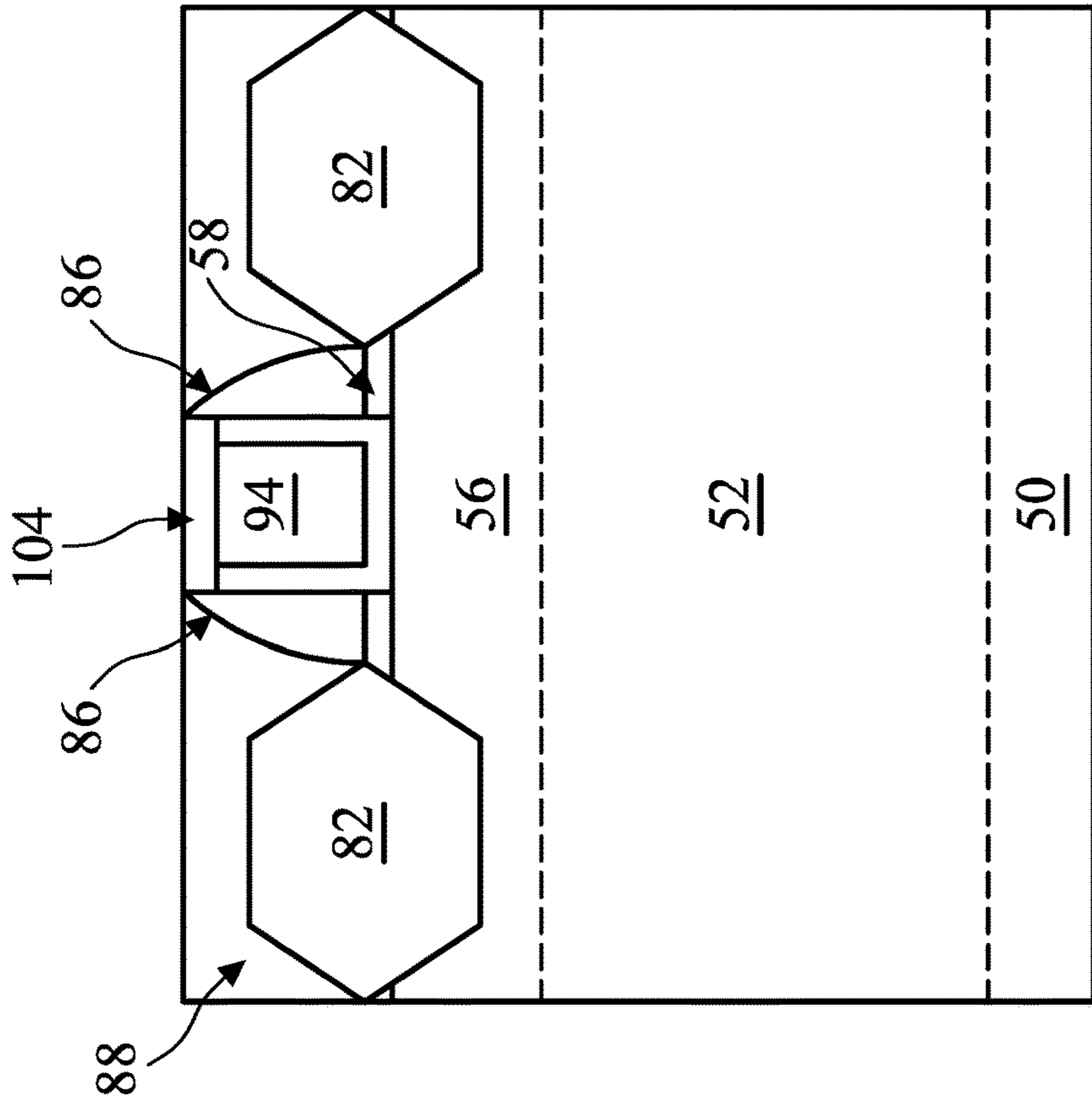


Figure 15C

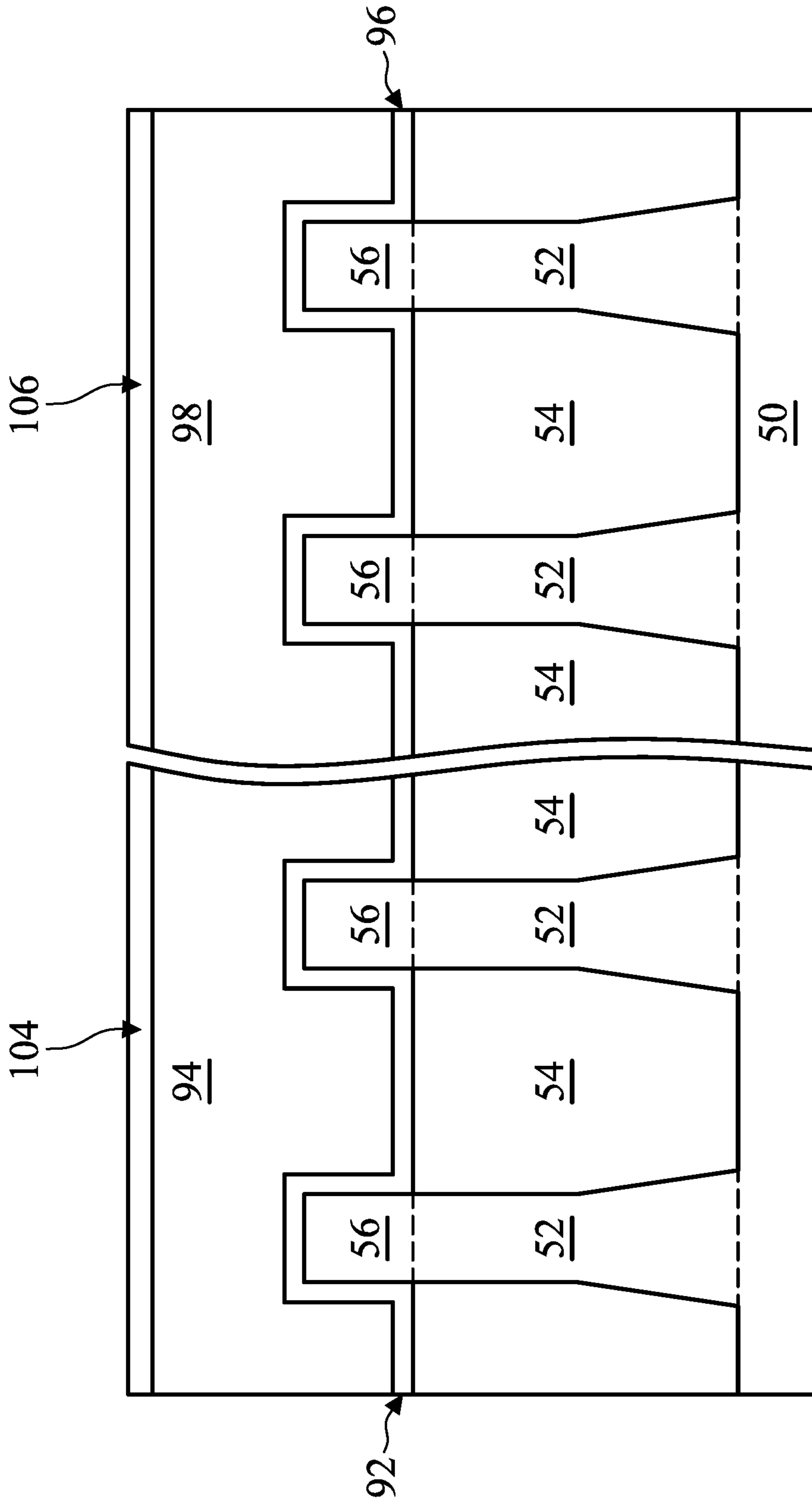


Figure 16A

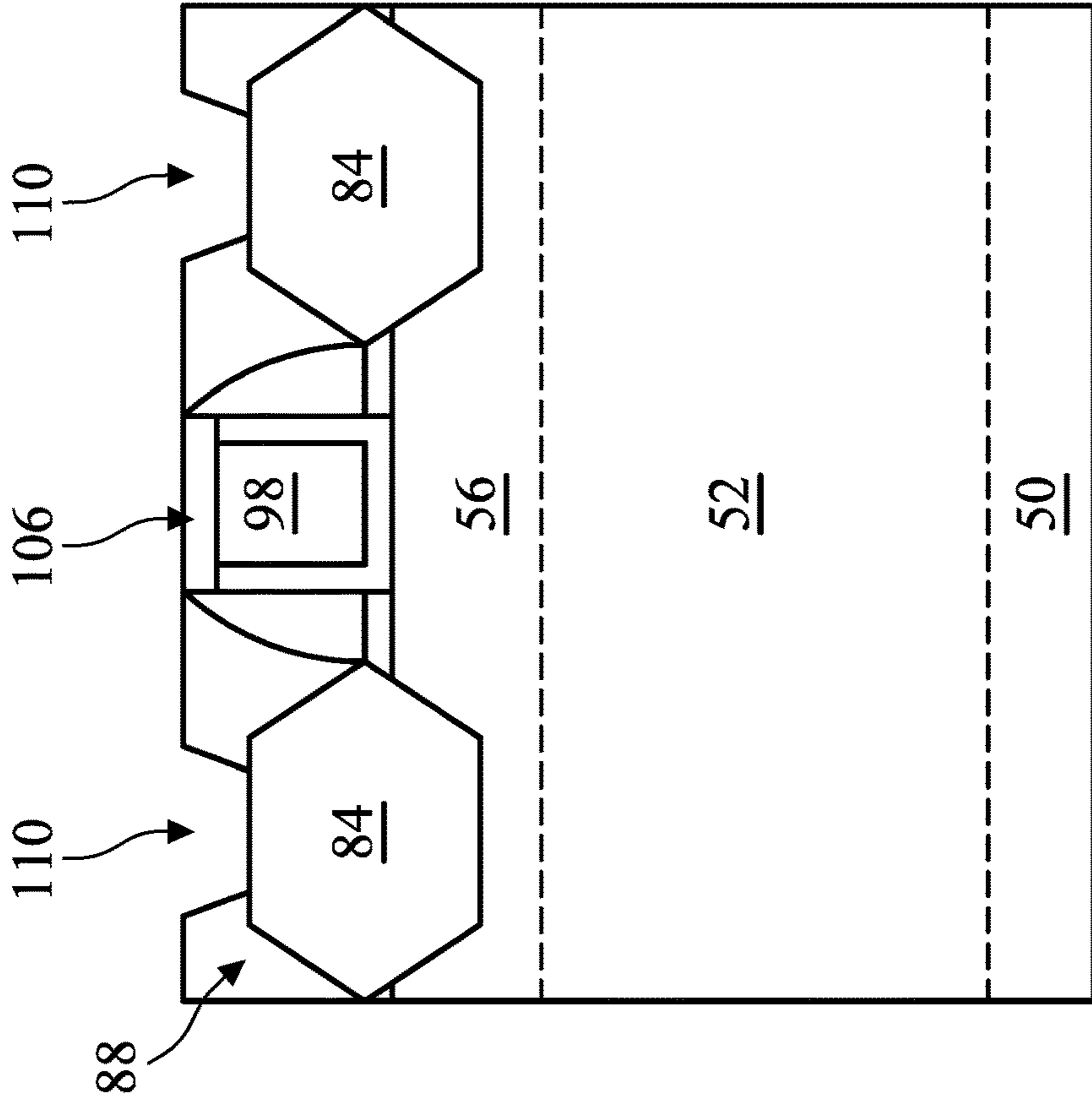


Figure 16B

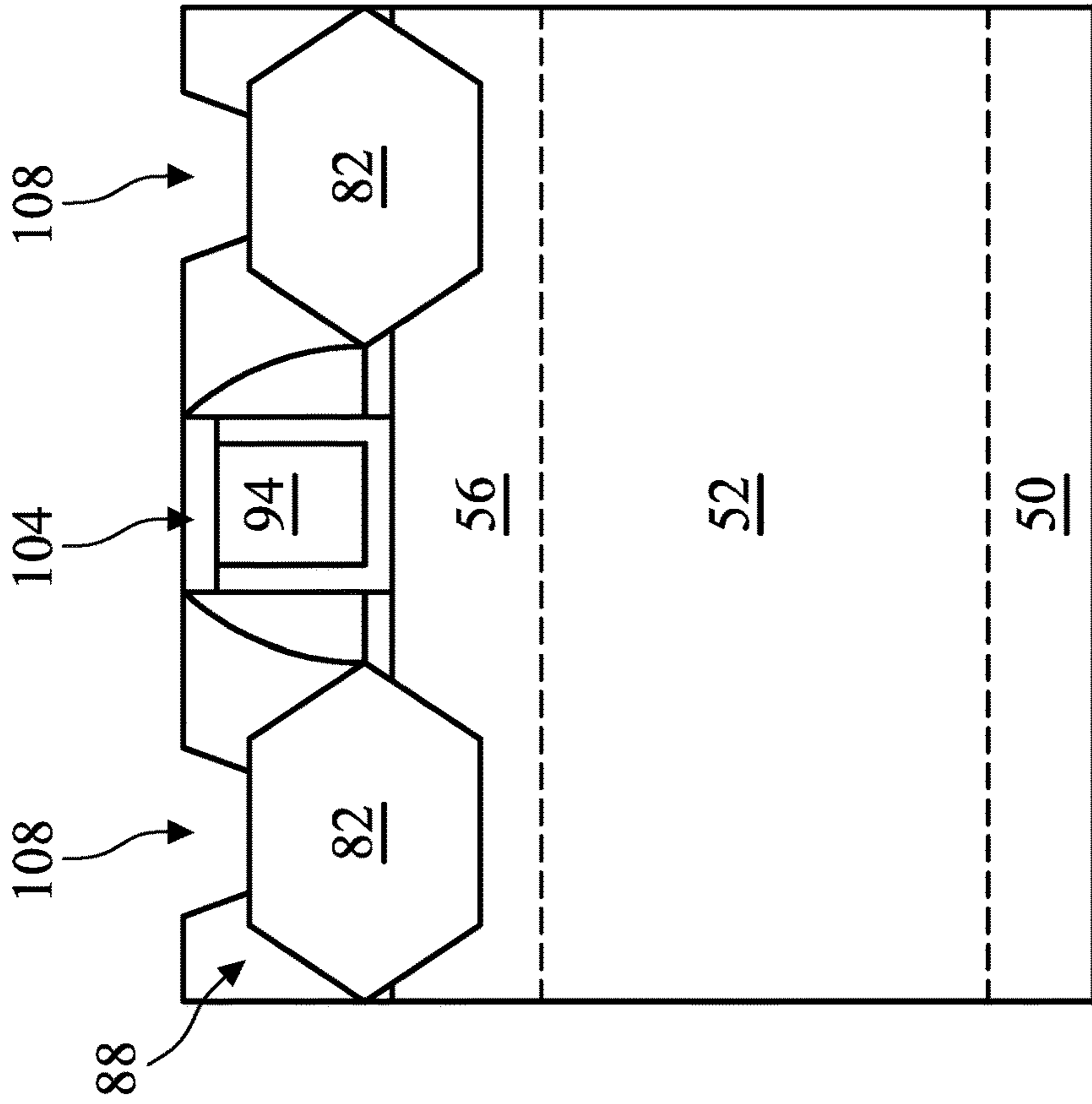


Figure 16C

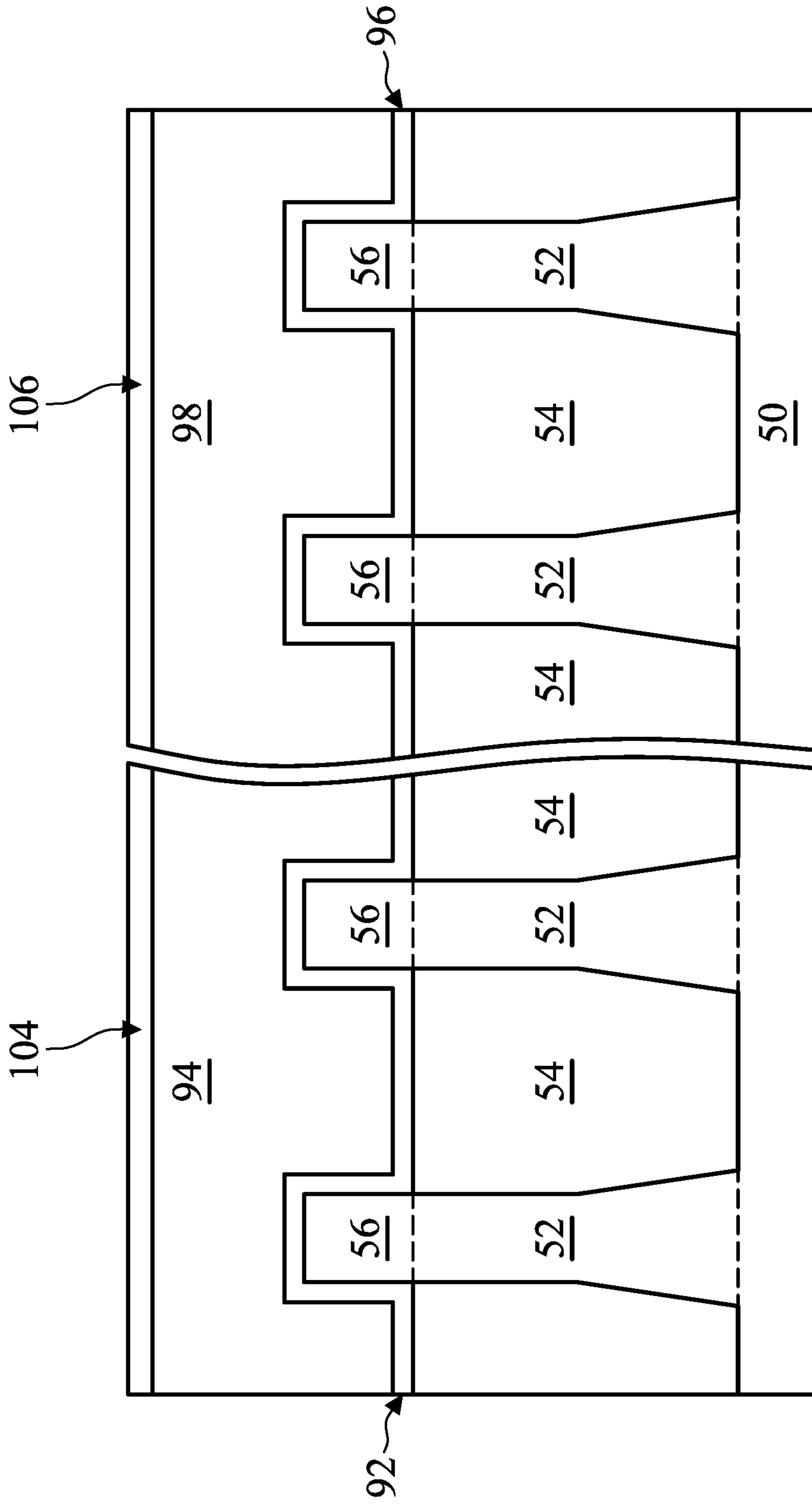


Figure 17A

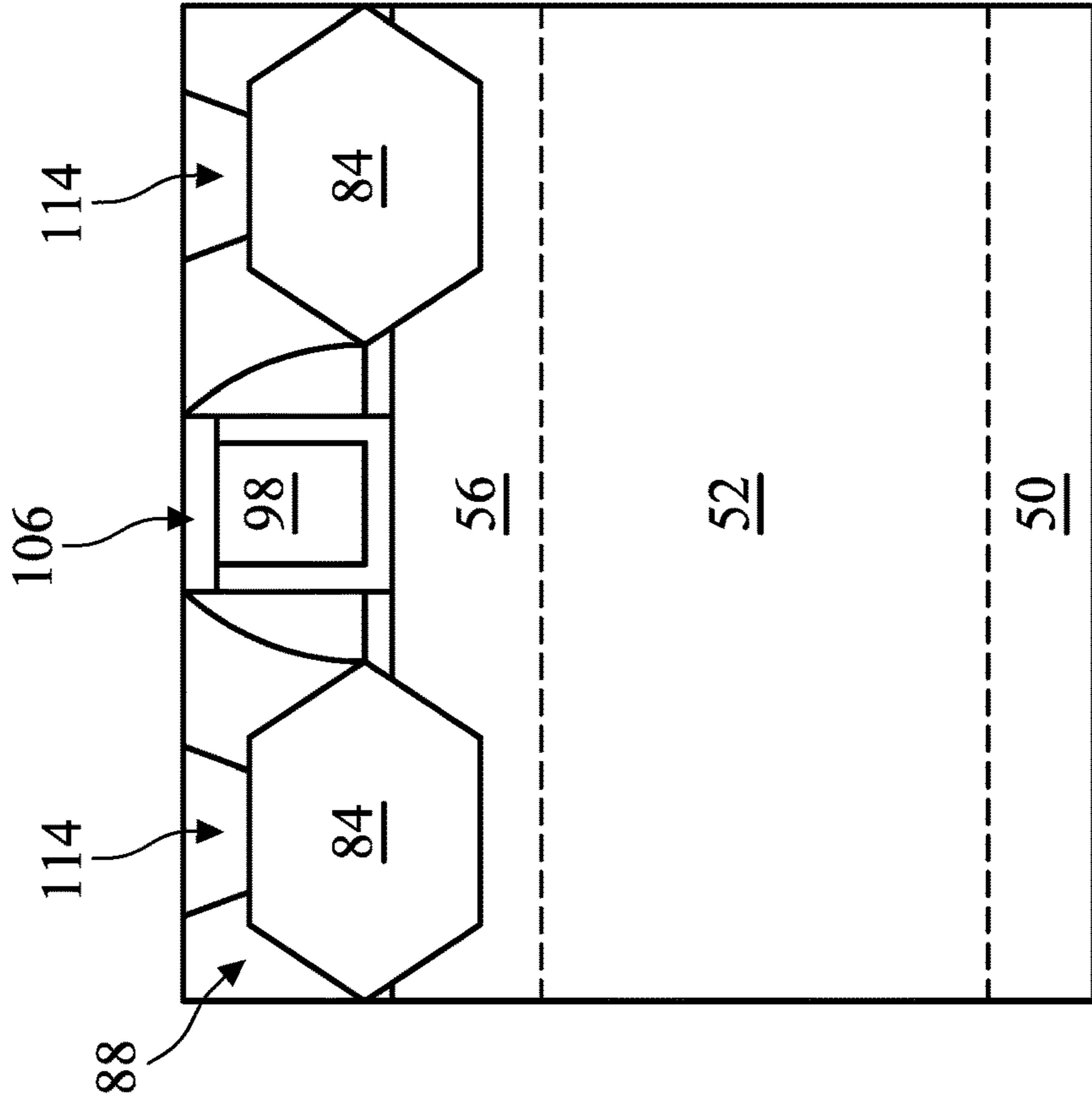


Figure 17B

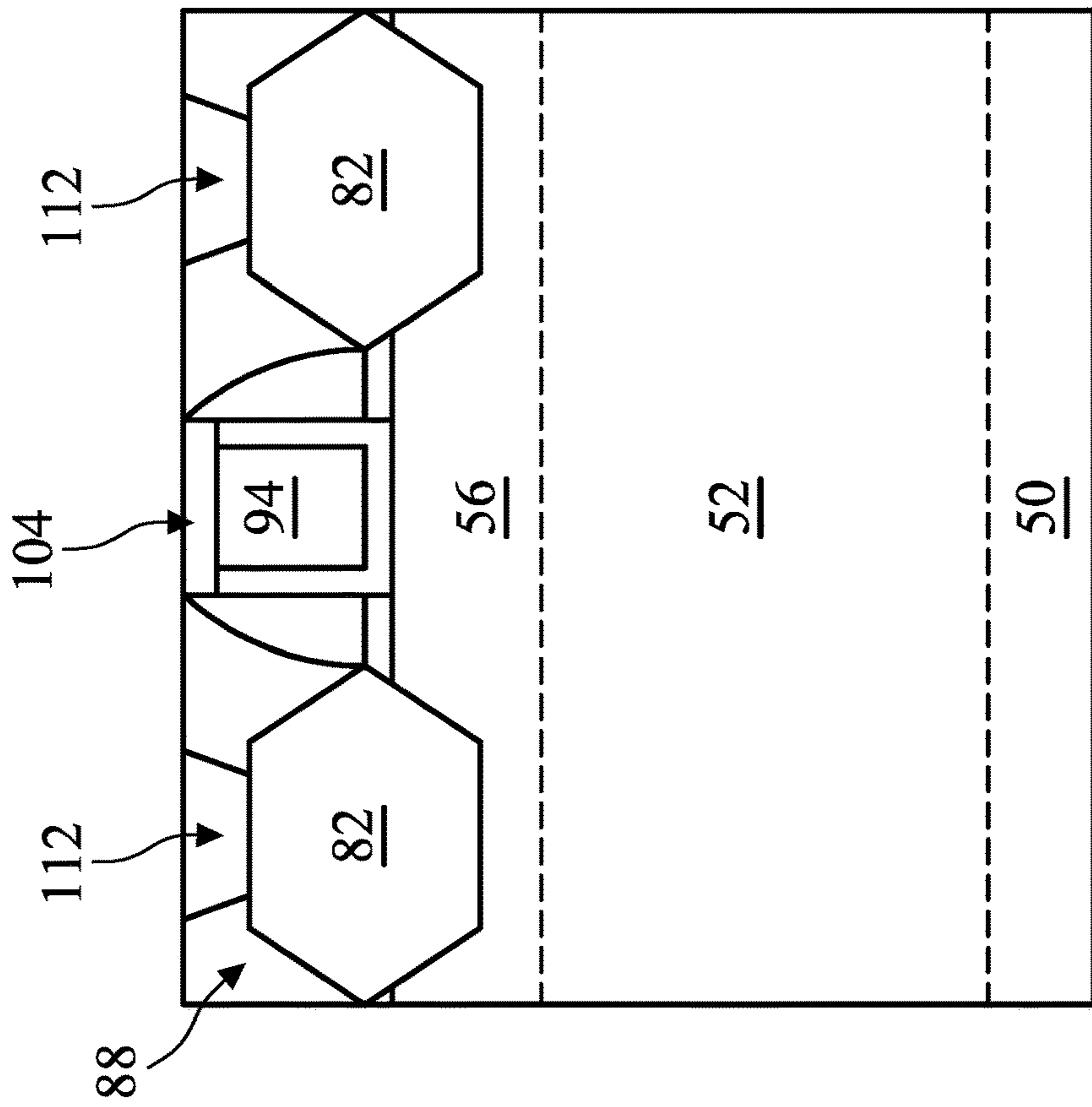


Figure 17C

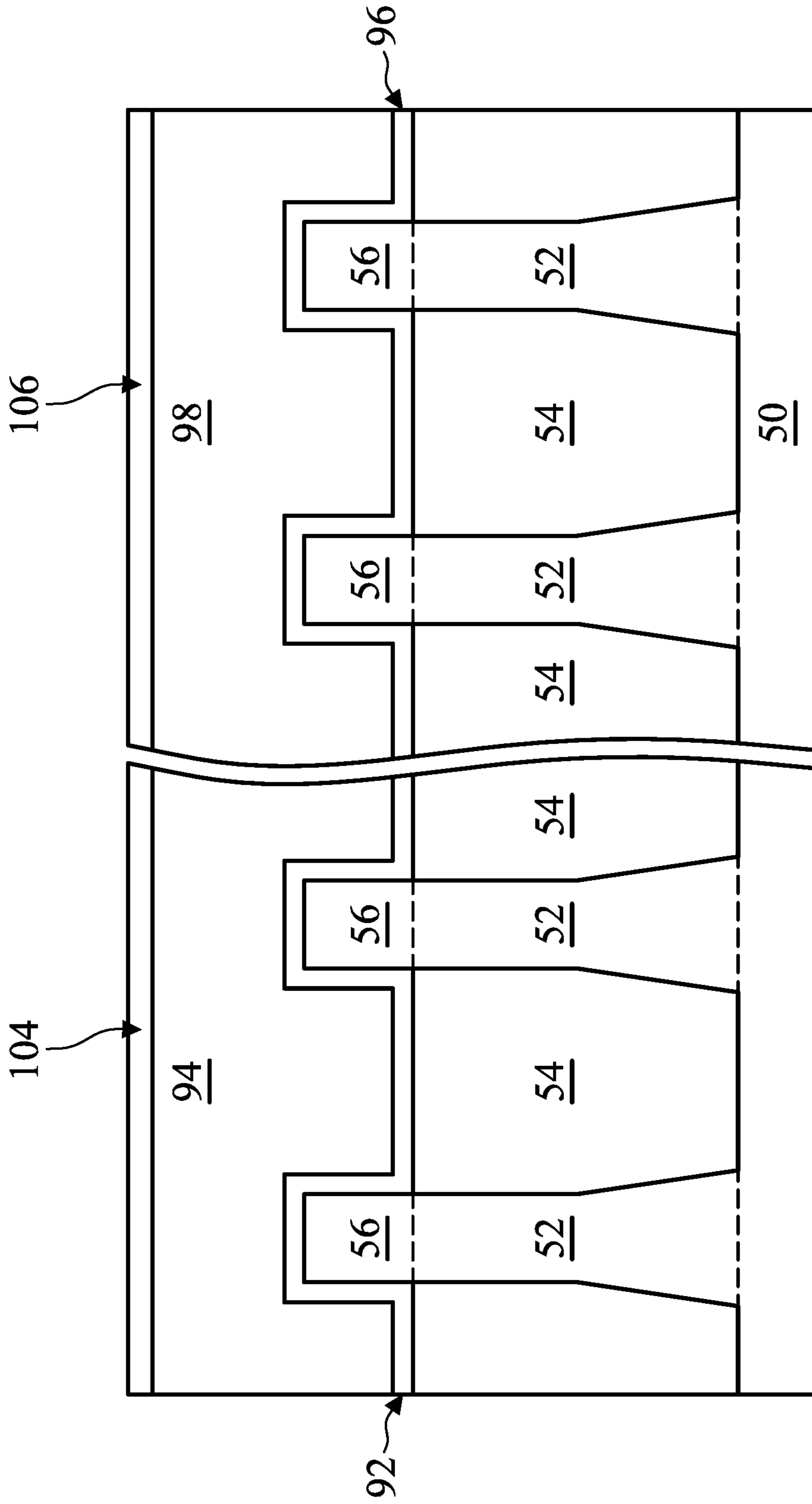


Figure 18A

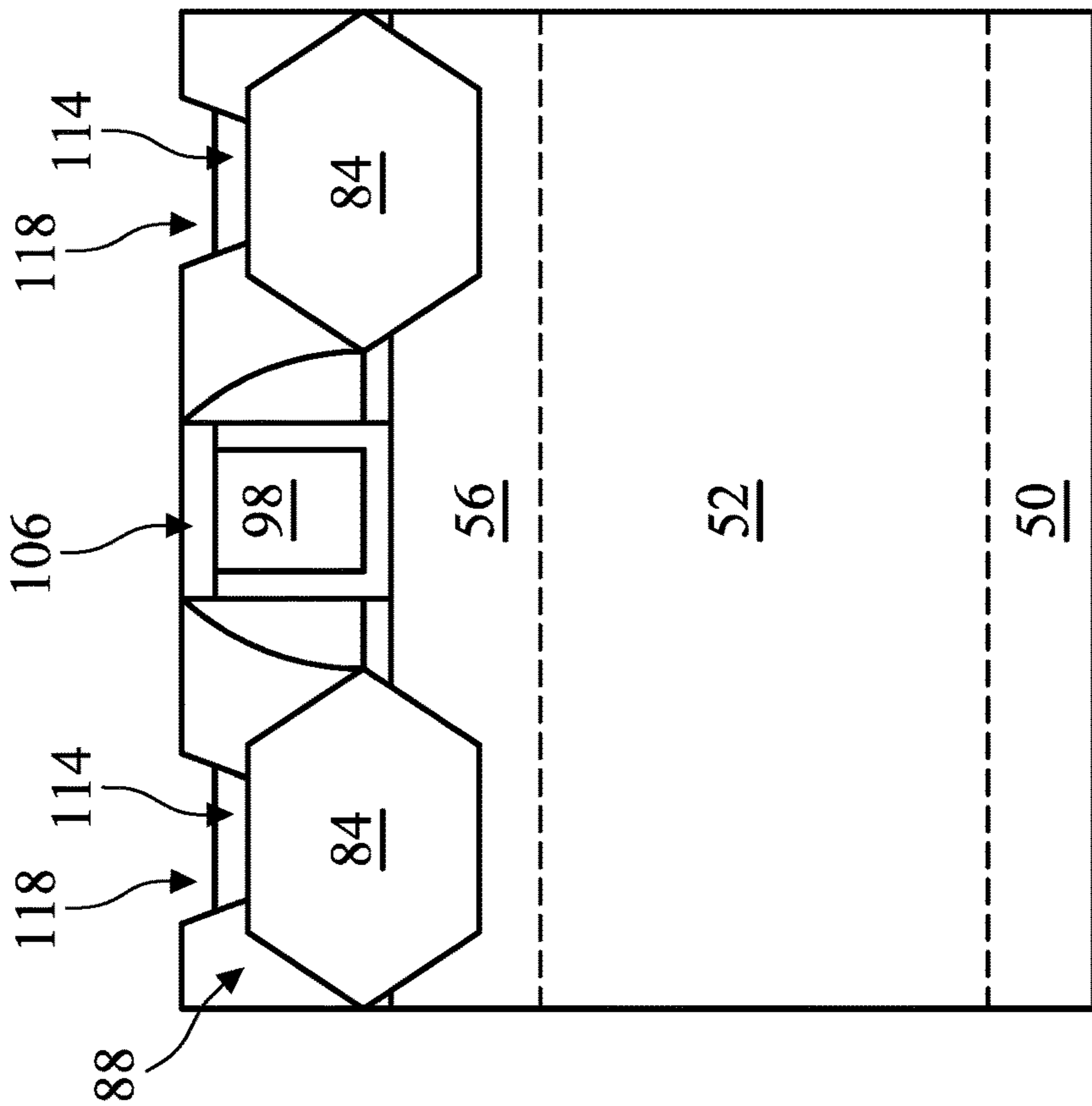


Figure 18B

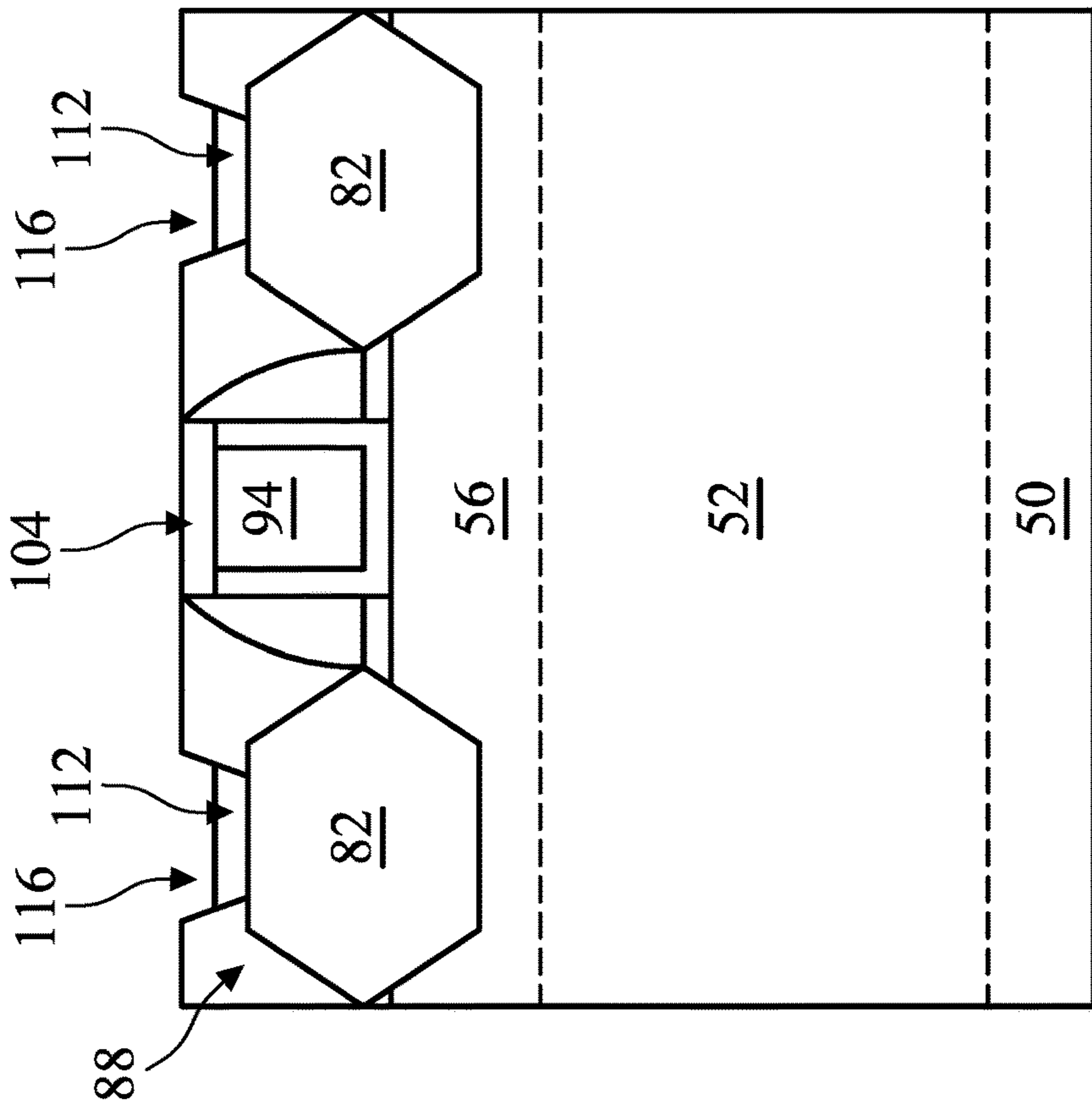


Figure 18C



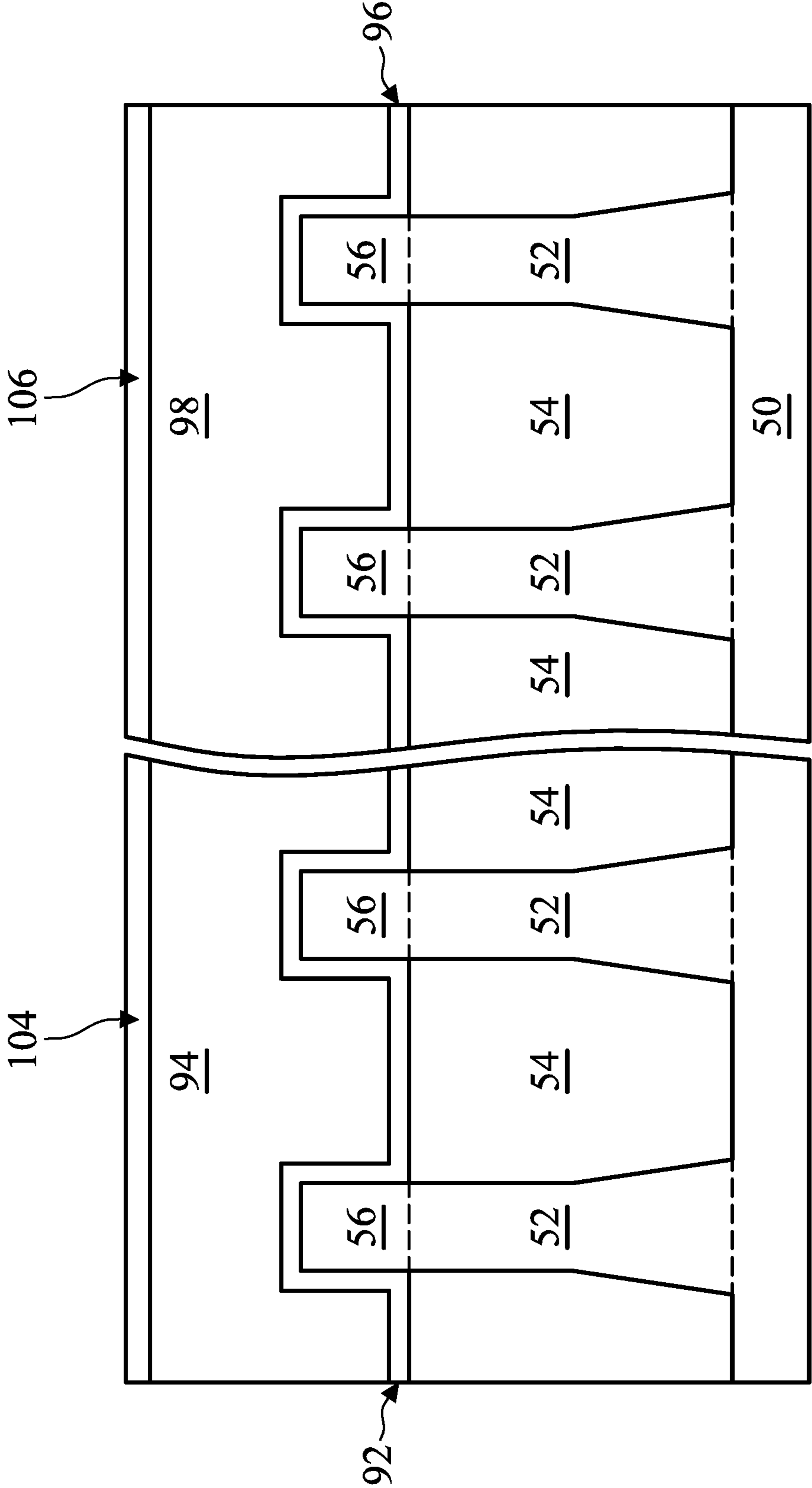


Figure 19A

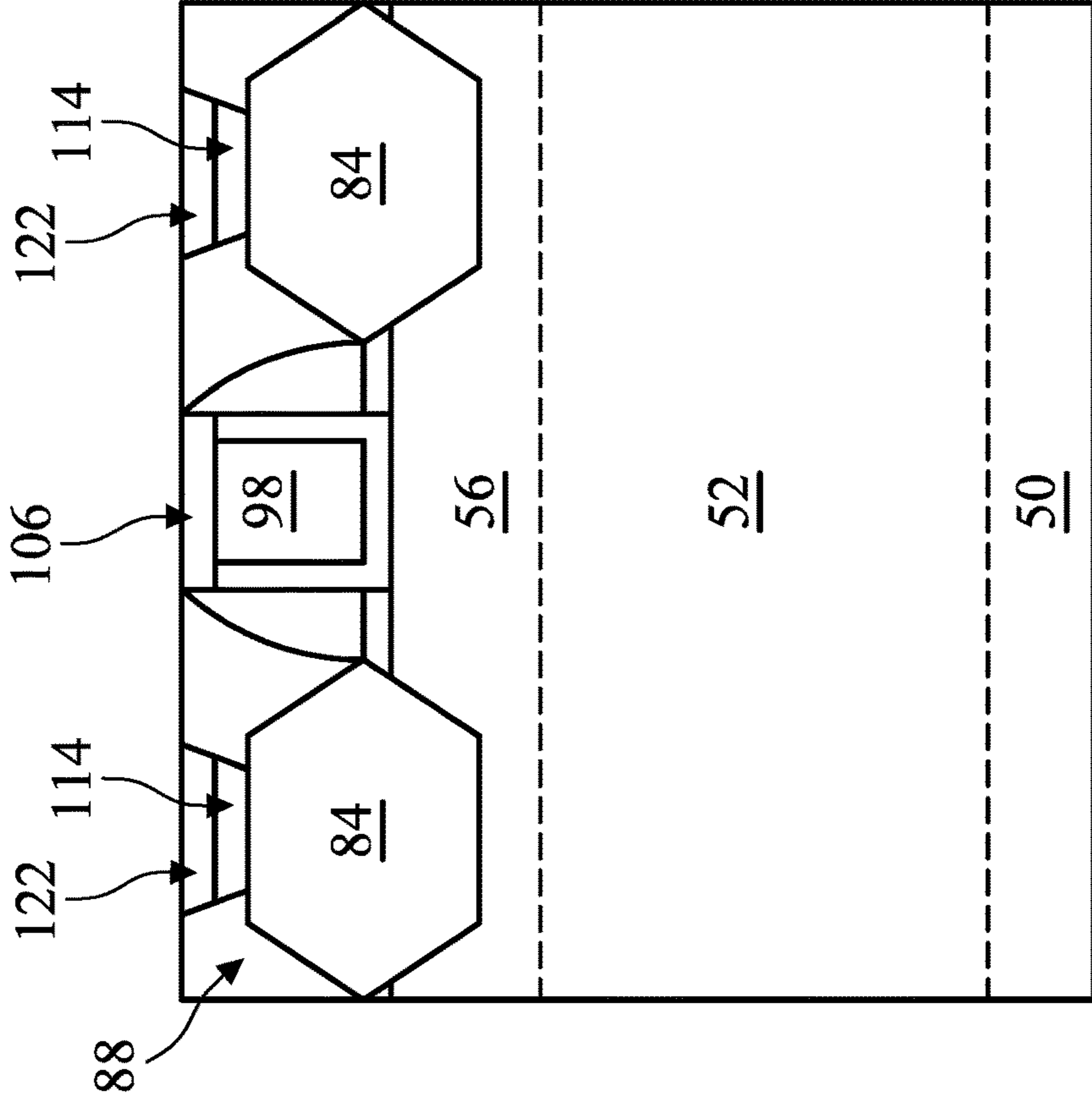


Figure 19B

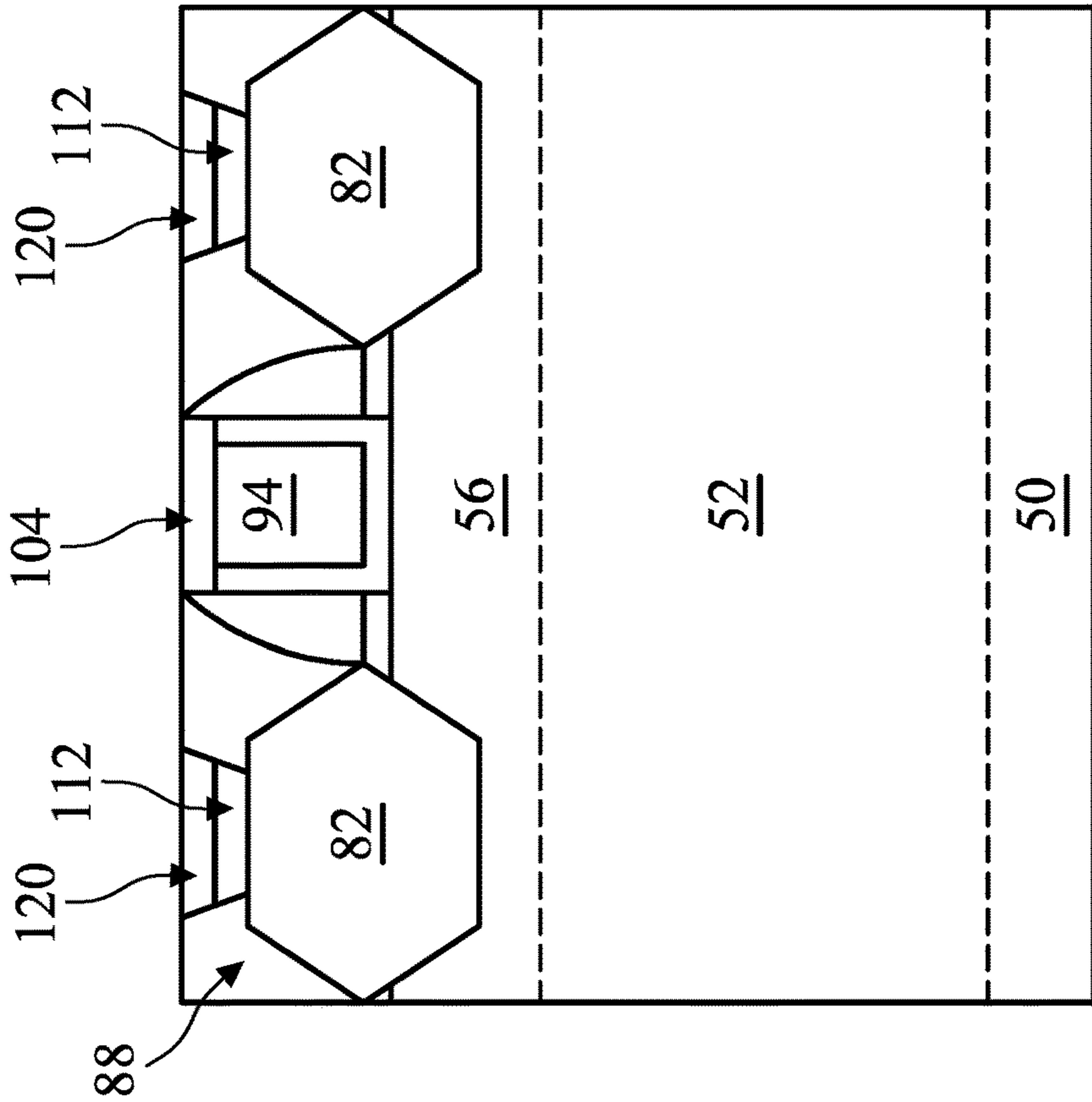


Figure 19C

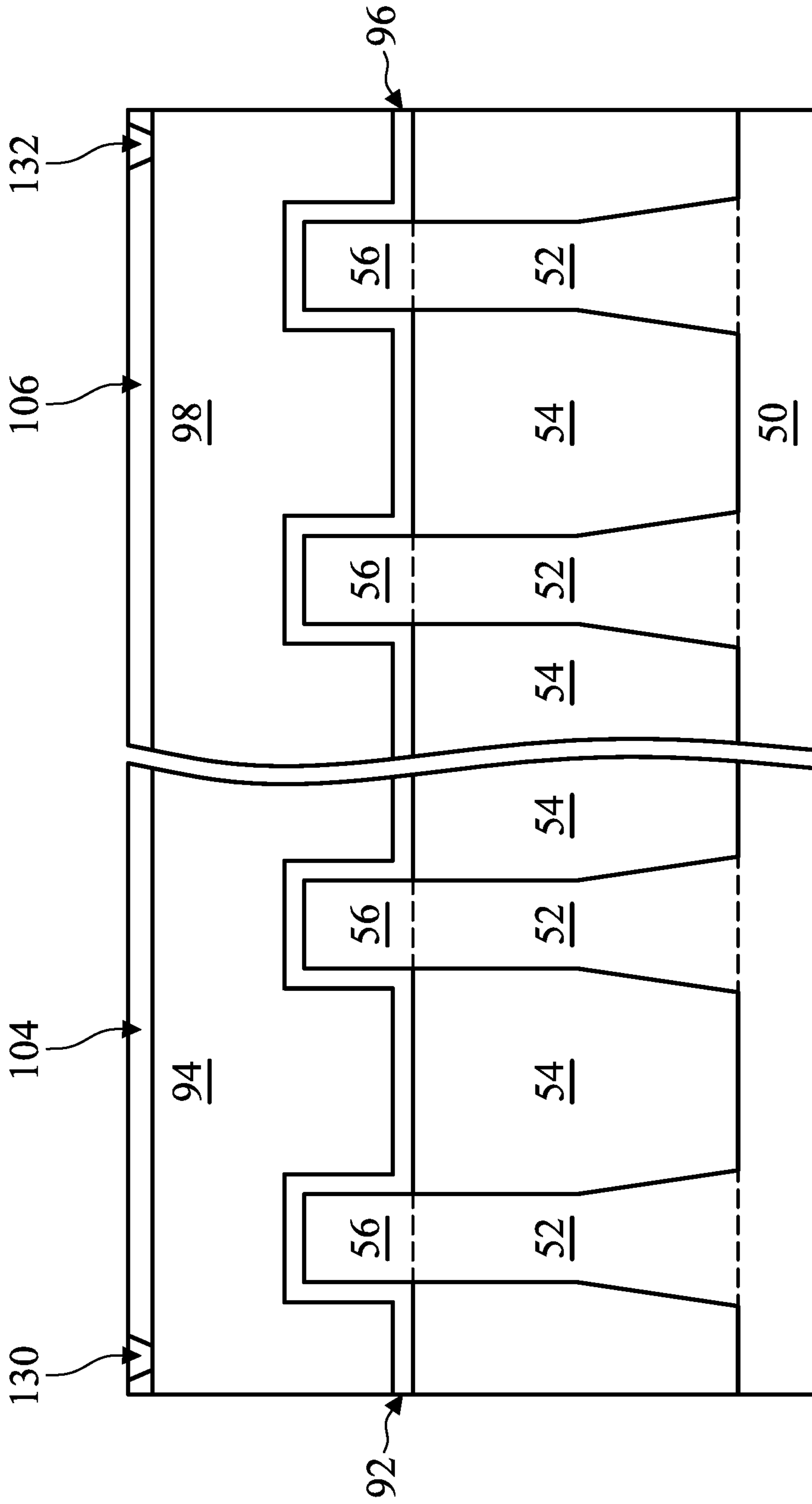


Figure 20A

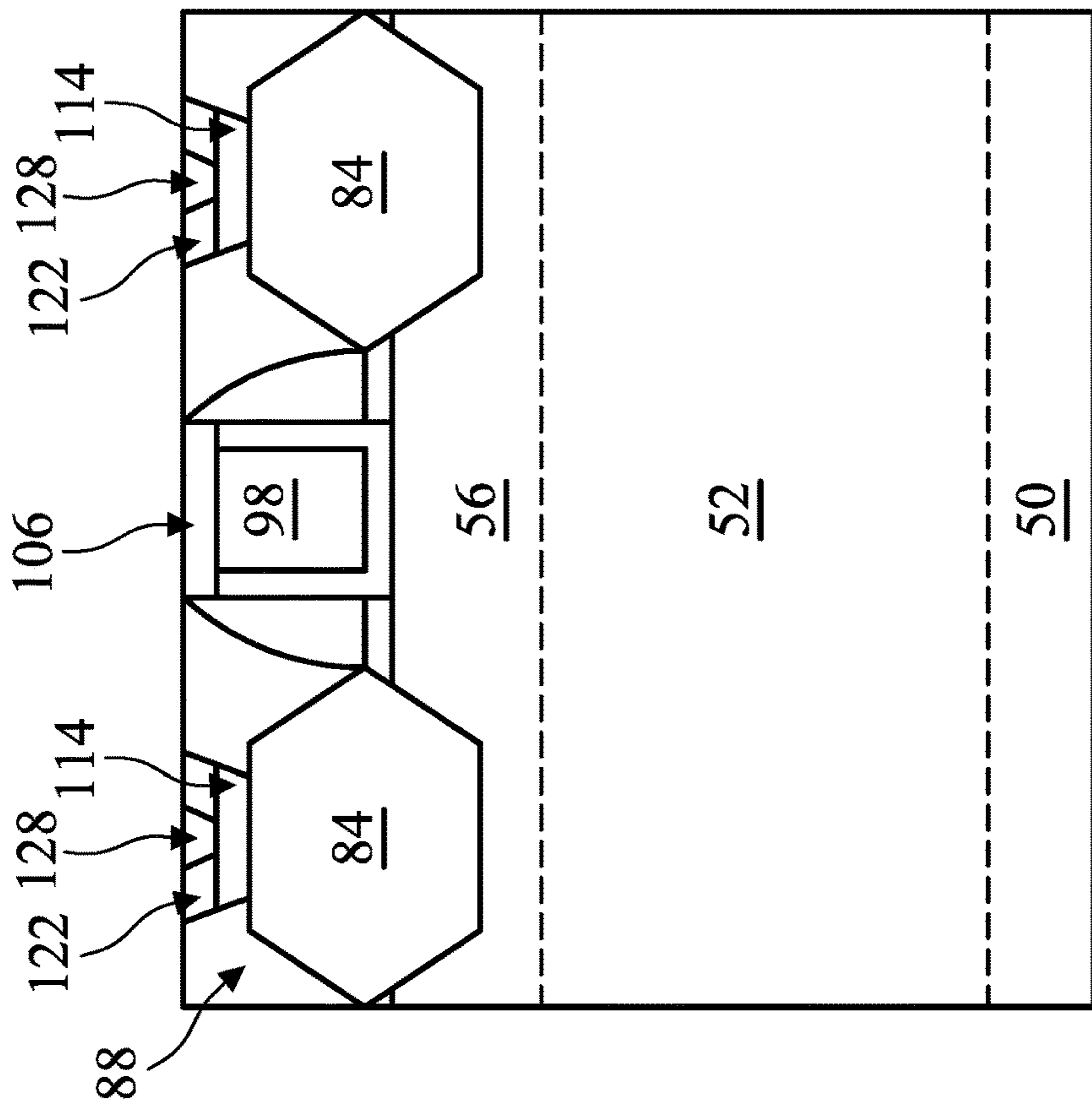


Figure 20B

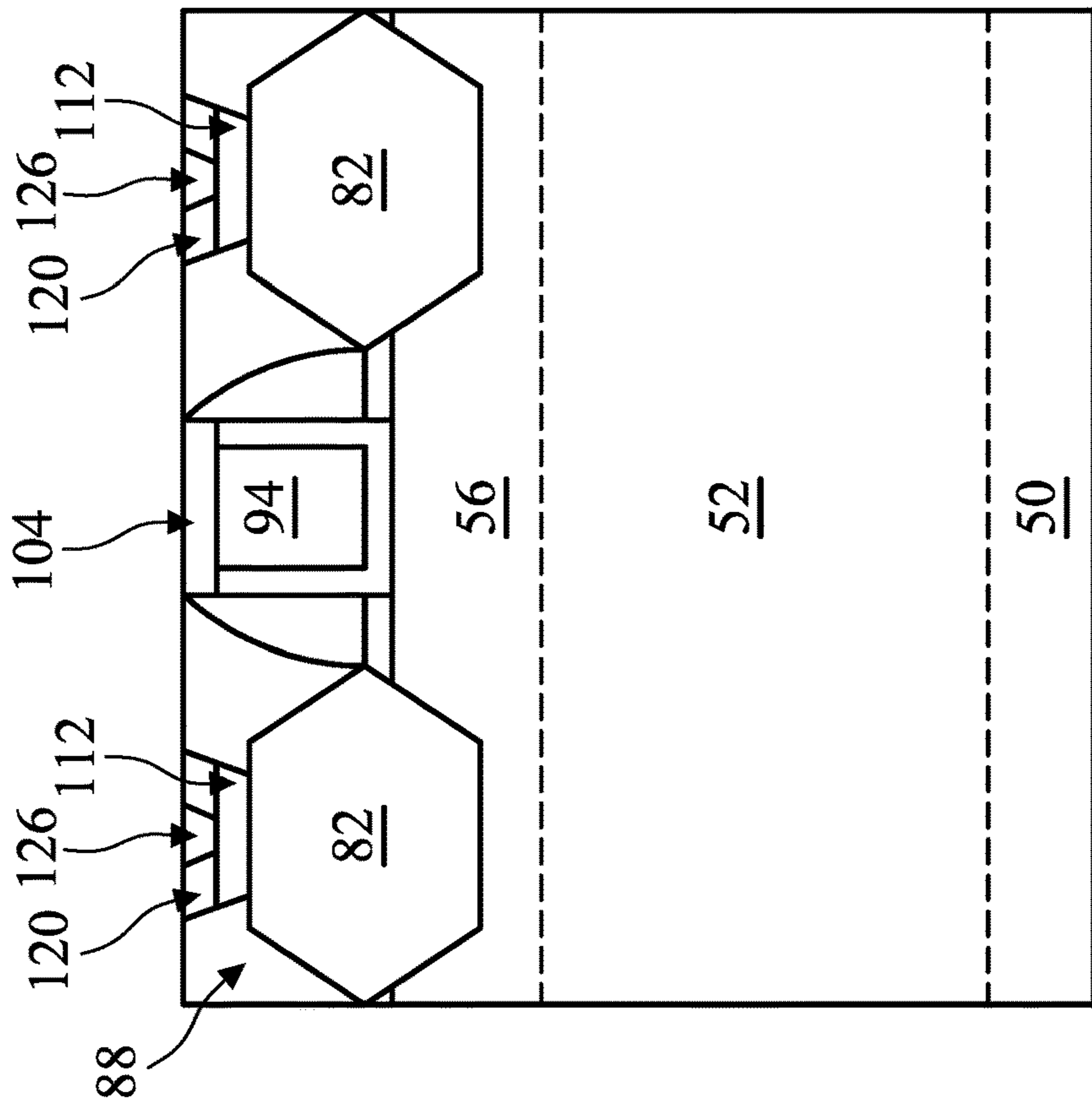


Figure 20C

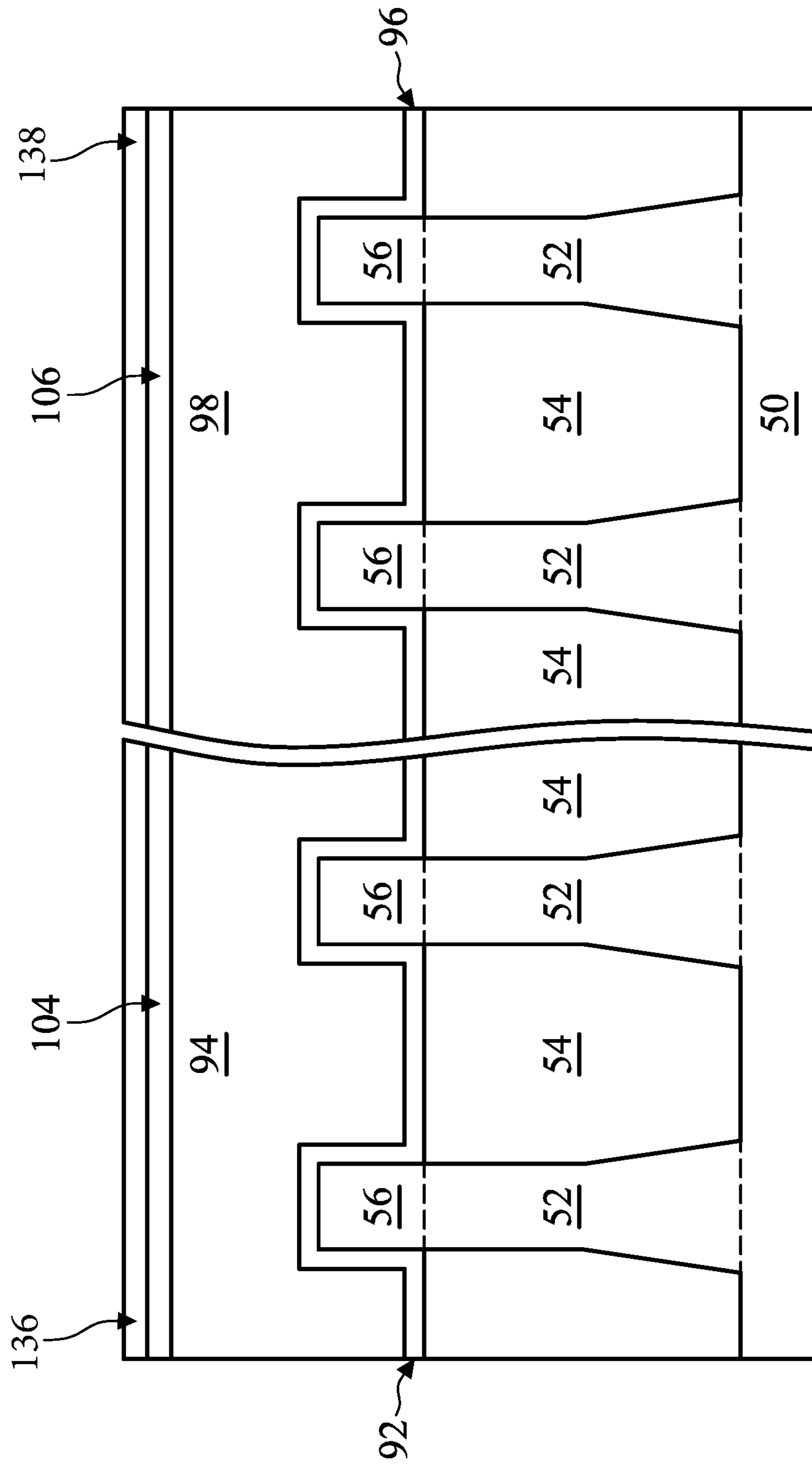


Figure 21A

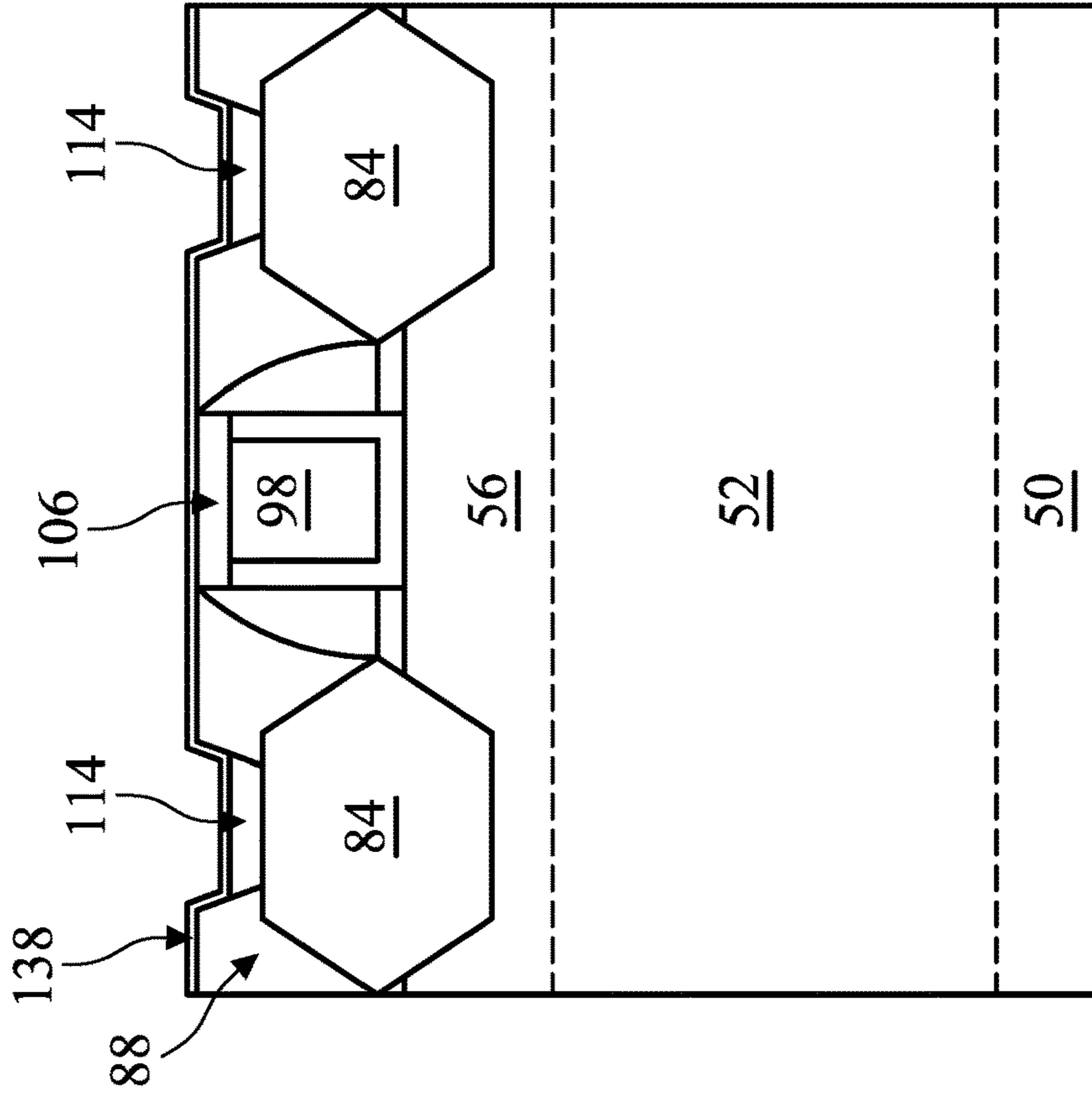


Figure 21B

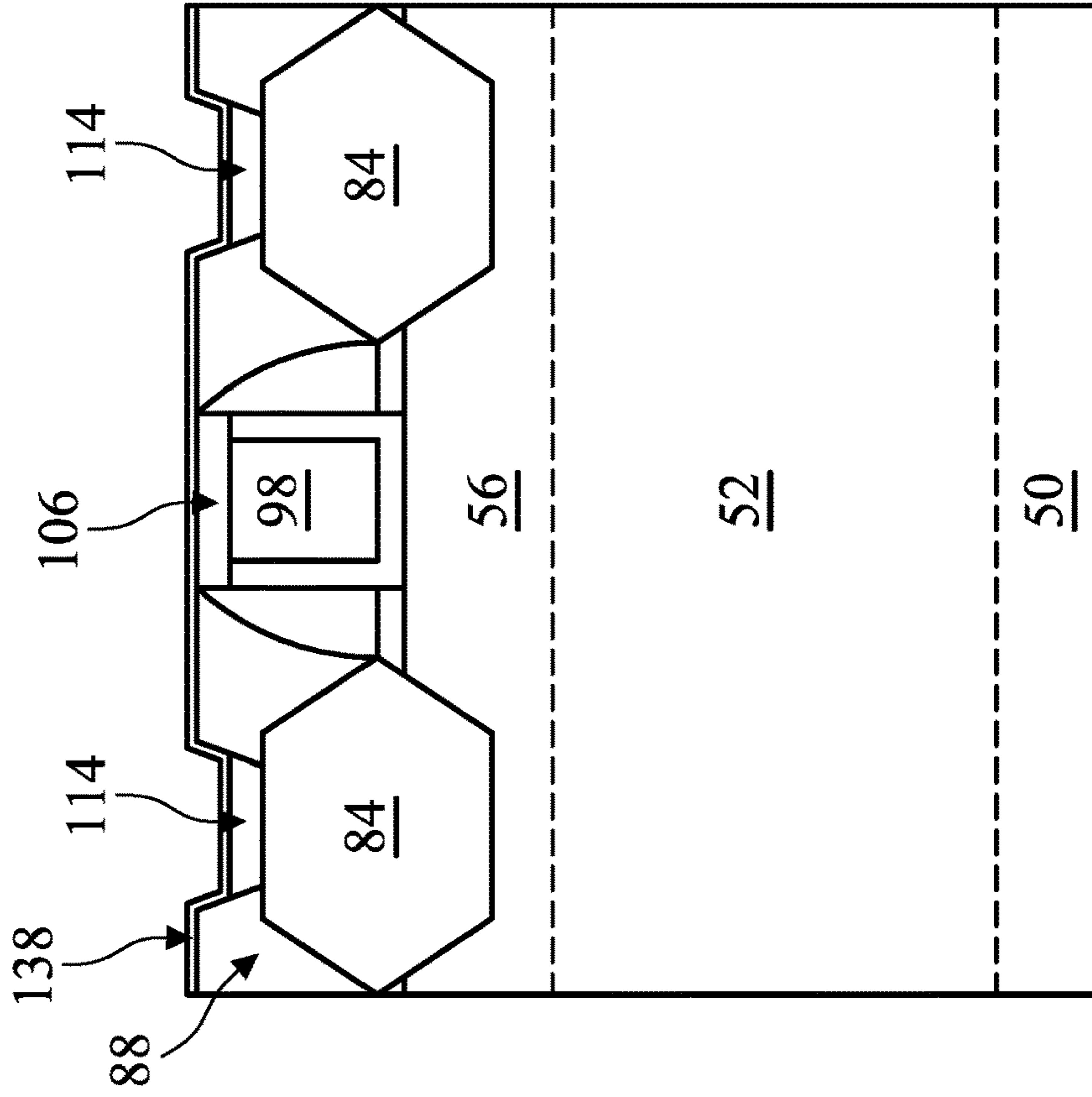


Figure 21C

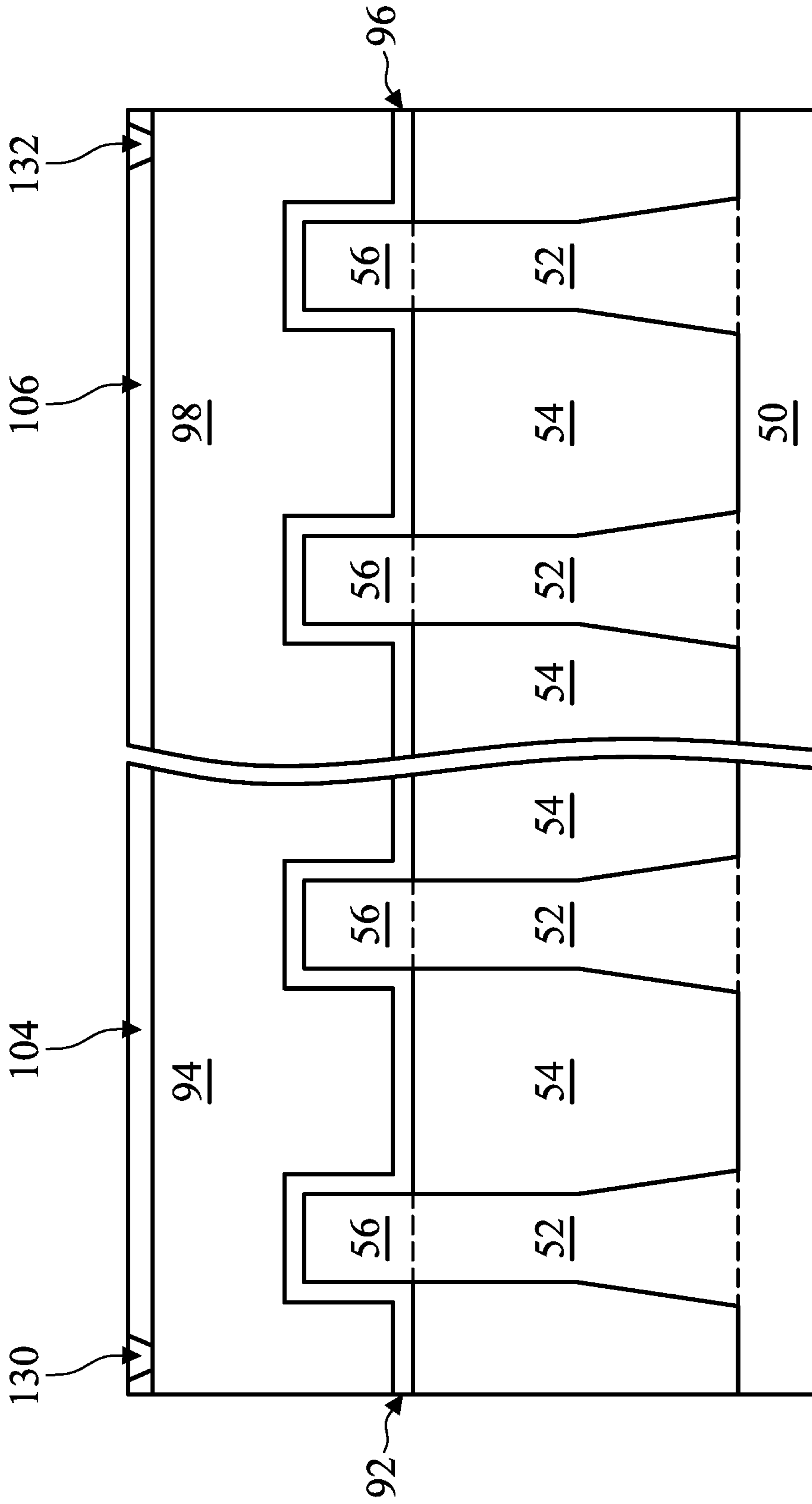


Figure 22A

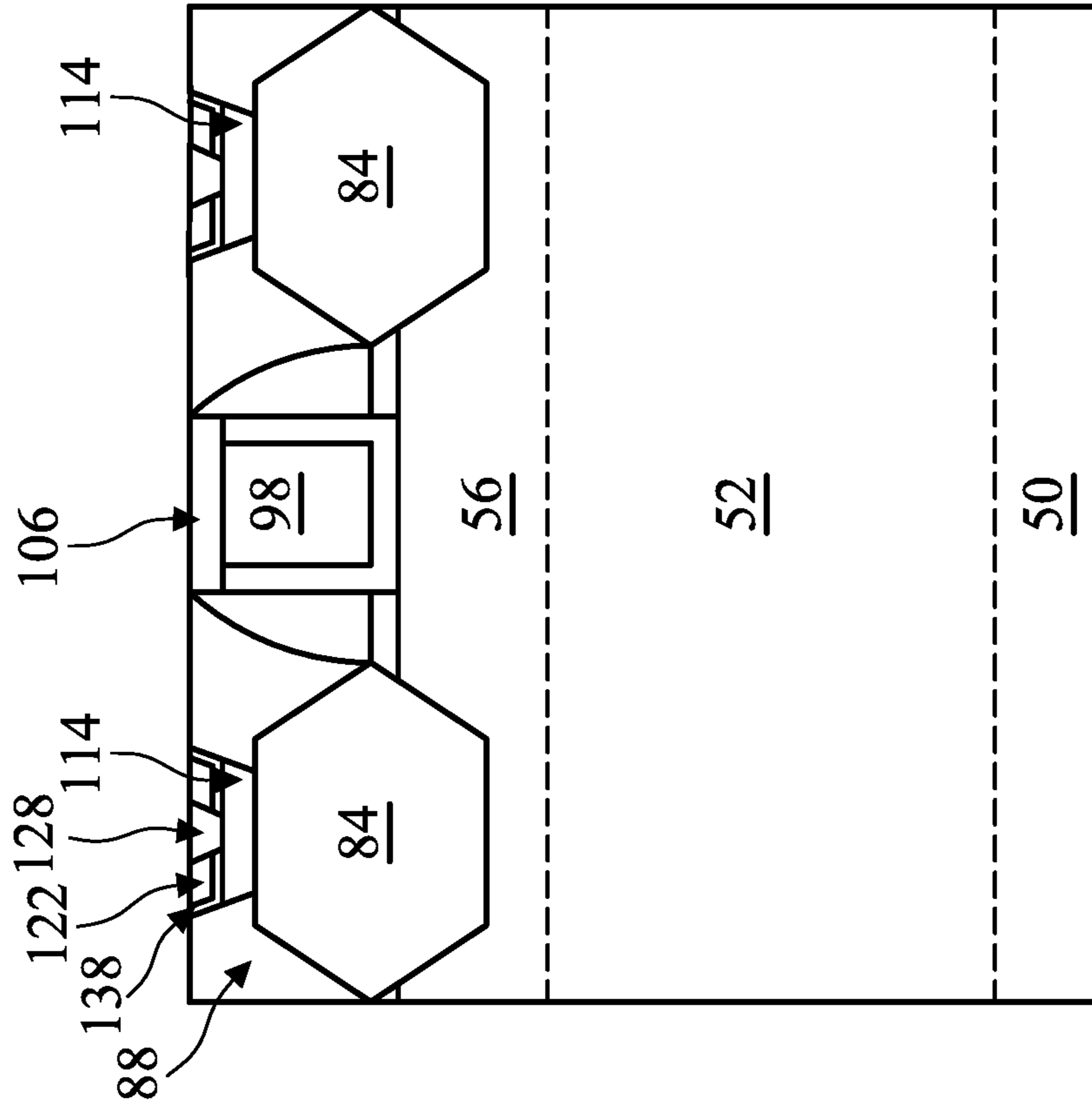


Figure 22B

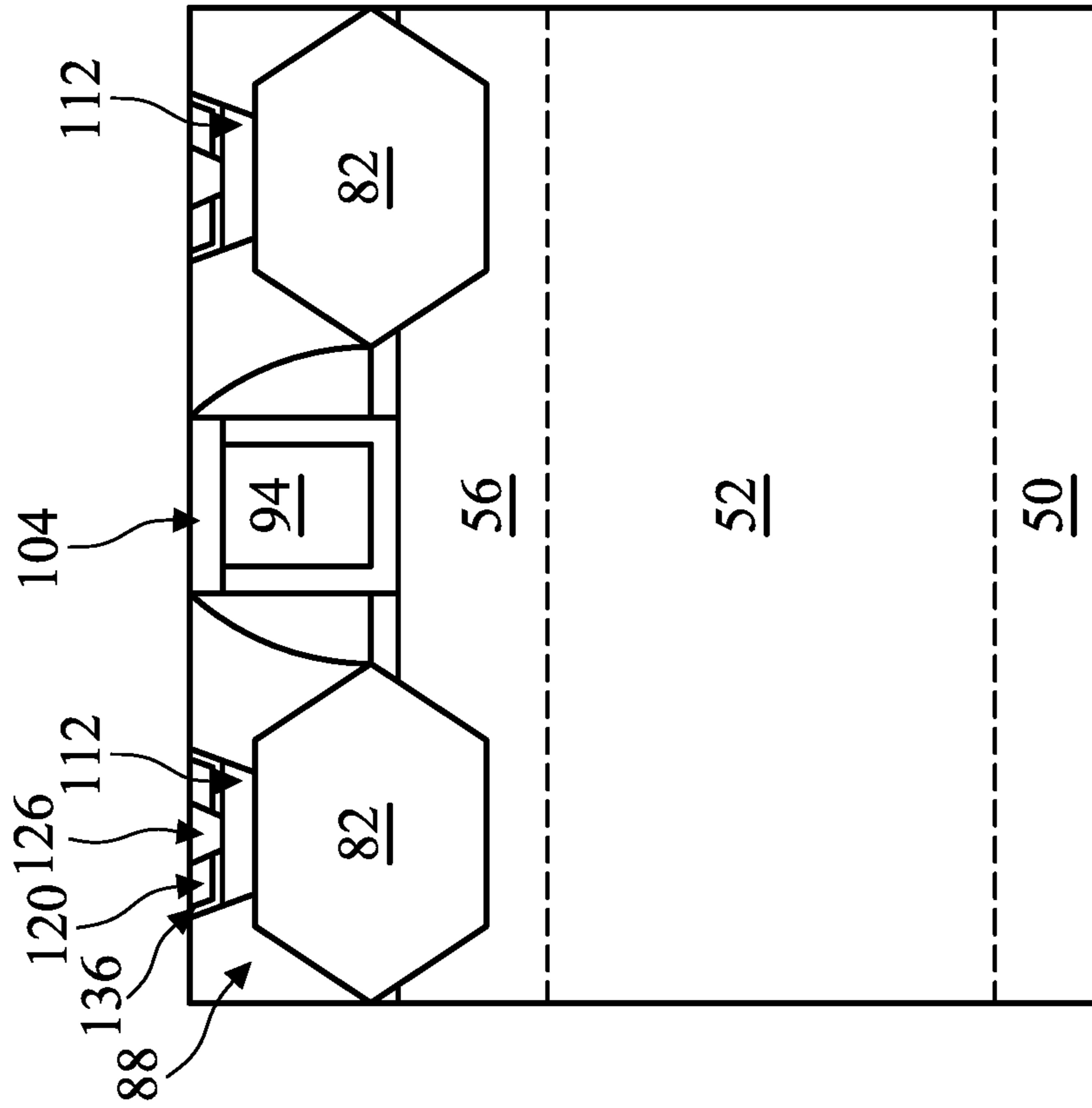


Figure 22C



## FINFETS AND METHODS OF FORMING FINFETS

This application is a divisional of U.S. patent application Ser. No. 16/229,118, filed on Dec. 21, 2018, entitled “FinFETs and Methods of Forming FinFETs,” which is a continuation of U.S. patent application Ser. No. 15/991,680, filed on May 29, 2018 (now U.S. Pat. No. 10,164,114 issued Dec. 25, 2018), entitled “FinFETs and Methods of Forming FinFETs,” which is a divisional of U.S. patent application Ser. No. 15/455,603, filed on Mar. 10, 2017 (now U.S. Pat. No. 9,985,134, issued May 29, 2018), entitled “FinFETs and Methods of Forming FinFETs,” which claims the benefit of U.S. Provisional Application No. 62/427,584, filed on Nov. 29, 2016, which applications are hereby incorporated herein by reference in its entirety.

### BACKGROUND

As the semiconductor industry has progressed into nanometer technology process nodes in pursuit of higher device density, higher performance, and lower costs, challenges from both fabrication and design issues have resulted in the development of three-dimensional designs, such as a fin field effect transistor (FinFET). A typical FinFET is fabricated with a thin vertical “fin” (or fin structure) extending from a substrate formed by, for example, etching away a portion of a silicon layer of the substrate. The channel of the FinFET is formed in this vertical fin. A gate is provided over (e.g., wrapping) the fin. Having a gate on both sides of the channel allows gate control of the channel from both sides. However, there are challenges to implementation of such features and processes in semiconductor fabrication.

### BRIEF DESCRIPTION OF THE DRAWINGS

Aspects of the present disclosure are best understood from the following detailed description when read with the accompanying figures. It is noted that, in accordance with the standard practice in the industry, various features are not drawn to scale. In fact, the dimensions of the various features may be arbitrarily increased or reduced for clarity of discussion.

FIG. 1 is an example of a Fin Field-Effect Transistor (FinFET) in a three-dimensional view.

FIGS. 2 through 6, 7A-7C, 8A-8C, 9A-9C, 10A-10C, 11A-11C, 12A-12C, 13A-13C, 14A-14C, 15A-15C, 16A-16C, 17A-17C, 18A-18C, 19A-19C, and 20A-20C are cross-sectional views of intermediate stages in the manufacturing of FinFETs in accordance with some embodiments.

FIGS. 21A-21C and 22A-22C are cross-sectional views of intermediate stages in the manufacturing of FinFETs in accordance with some embodiments.

### DETAILED DESCRIPTION

The following disclosure provides many different embodiments, or examples, for implementing different features of the invention. Specific examples of components and arrangements are described below to simplify the present disclosure. These are, of course, merely examples and are not intended to be limiting. For example, the formation of a first feature over or on a second feature in the description that follows may include embodiments in which the first and second features are formed in direct contact, and may also include embodiments in which additional features may be

formed between the first and second features, such that the first and second features may not be in direct contact. In addition, the present disclosure may repeat reference numerals and/or letters in the various examples. This repetition is for the purpose of simplicity and clarity and does not in itself dictate a relationship between the various embodiments and/or configurations discussed.

Further, spatially relative terms, such as “beneath,” “below,” “lower,” “above,” “upper” and the like, may be used herein for ease of description to describe one element or feature’s relationship to another element(s) or feature(s) as illustrated in the figures. The spatially relative terms are intended to encompass different orientations of the device in use or operation in addition to the orientation depicted in the figures. The apparatus may be otherwise oriented (rotated 90 degrees or at other orientations) and the spatially relative descriptors used herein may likewise be interpreted accordingly.

Fin Field-Effect Transistors (FinFETs) and methods of forming the same are provided in accordance with various embodiments. Intermediate stages of forming FinFETs are illustrated. Some embodiments discussed herein are discussed in the context of FinFETs formed using a gate-first process. In other embodiments, a gate-last process (sometimes referred to as replacement gate process) may be used. Some variations of the embodiments are discussed. One of ordinary skill in the art will readily understand other modifications that may be made that are contemplated within the scope of other embodiments. Although method embodiments are discussed in a particular order, various other method embodiments may be performed in any logical order and may include fewer or more steps described herein.

Before addressing the illustrated embodiments specifically, certain advantageous features and aspects of the present disclosed embodiments will be addressed generally. In general terms, the present disclosure is a semiconductor device and method of forming the same to provide a simple and cost-effective process flow to reduce the possibility of electrical shorts/leakage between a gate electrode and source/drain contacts when forming vias to the gate electrode. In addition, this simple and cost-effective process flow allows for the layout of the gate electrode to be shortened as the via to the gate electrode can be closer to the vias for the source/drain contacts. In particular, embodiments such as those disclosed below include a process flow that utilizes a mask over both the gate electrode and the source/drain contacts to allow for vias to the gate electrode and the source/drain contacts to both be self-aligned. These masks over the gate electrode and the source/drain contacts ensure that the overlying vias do not electrically short the gate electrode to the source/drain contacts even when the overlying vias are misaligned.

FIG. 1 illustrates an example of a fin field-effect transistor (FinFET) 30 in a three-dimensional view. The FinFET 30 comprises a fin 36 on a substrate 32. The substrate 32 includes isolation regions 34, and the fin 36 protrudes above and from between neighboring isolation regions 34. A gate dielectric 38 is along sidewalls and over a top surface of the fin 36, and a gate electrode 40 is over the gate dielectric 38. Source/drain regions 42 and 44 are disposed in opposite sides of the fin 36 with respect to the gate dielectric 38 and gate electrode 40. FIG. 13 further illustrates reference cross-sections that are used in later figures. Cross-section A-A is across a channel, gate dielectric 38, and gate electrode 40 of the FinFET 30. Cross-section B/C-B/C is perpendicular to cross-section A-A and is along a longitudinal axis of the fin 36 and in a direction of, for example, a current flow between

the source/drain regions **42** and **44**. Subsequent figures refer to these reference cross-sections for clarity.

Some embodiments discussed herein are discussed in the context of FinFETs formed using a gate-last process. In other embodiments, a gate-first process may be used. Also, some embodiments contemplate aspects used in planar devices, such as planar FETs.

FIGS. **2** through **20C** are cross-sectional views of intermediate stages in the manufacturing of FinFETs in accordance with an exemplary embodiment. FIGS. **2** through **6** illustrate reference cross-section A-A illustrated in FIG. **1**, except for multiple FinFETs. In FIGS. **7A** through **20C**, figures ending with an "A" designation are illustrated along a similar cross-section A-A; figures ending with a "B" designation are illustrated along a similar cross-section B/C-B/C and in a first region on a substrate; and figures ending with a "C" designation are illustrated along a similar cross-section B/C-B/C and in a second region on a substrate.

FIG. **2** illustrates a substrate **50**. Substrate **50** may be a semiconductor substrate, such as a bulk semiconductor, a semiconductor-on-insulator (SOI) substrate, or the like, which may be doped (e.g., with a p-type or an n-type dopant) or undoped. The substrate **50** may be a wafer, such as a silicon wafer. Generally, an SOI substrate comprises a layer of a semiconductor material formed on an insulator layer. The insulator layer may be, for example, a buried oxide (BOX) layer, a silicon oxide layer, or the like. The insulator layer is provided on a substrate, typically a silicon or glass substrate. Other substrates, such as a multi-layered or gradient substrate may also be used. In some embodiments, the semiconductor material of the substrate **50** may include silicon; germanium; a compound semiconductor including silicon carbide, gallium arsenic, gallium phosphide, indium phosphide, indium arsenide, and/or indium antimonide; an alloy semiconductor including SiGe, GaAsP, AlInAs, AlGaAs, GaInAs, GaInP, and/or GaInAsP; or combinations thereof.

The substrate **50** has a first region **50B** and a second region **50C**. The first region **50B** (which corresponds to subsequent figures ending in "B") can be for forming n-type devices, such as NMOS transistors, such as n-type FinFETs. The second region **50C** (which corresponds to subsequent figures ending in "C") can be for forming p-type devices, such as PMOS transistors, such as p-type FinFETs.

FIGS. **3** and **4** illustrate the formation of fins **52** and isolation regions **54** between neighboring fins **52**. In FIG. **3** fins **52** are formed in the substrate **50**. In some embodiments, the fins **52** may be formed in the substrate **50** by etching trenches in the substrate **50**. The etching may be any acceptable etch process, such as a reactive ion etch (RIE), neutral beam etch (NBE), the like, or a combination thereof. The etch may be anisotropic.

In FIG. **4** an insulation material **54** is formed between neighboring fins **52** to form the isolation regions **54**. The insulation material **54** may be an oxide, such as silicon oxide and/or a carbon-containing oxide, a nitride, the like, or a combination thereof, and may be formed by a high density plasma chemical vapor deposition (HDP-CVD), a flowable CVD (FCVD) (e.g., a CVD-based material deposition in a remote plasma system and post curing to make it convert to another material, such as an oxide), spin-on coating, the like, or a combination thereof. Other insulation materials formed by any acceptable process may be used. An anneal process may be performed once the insulation material is formed. In the illustrated embodiment, the insulation material **54** is silicon oxide formed by a FCVD process. The insulating material **54** may be referred to as isolation regions **54**.

Further in FIG. **4**, a planarization process, such as a chemical mechanical polish (CMP), may remove any excess insulation material **54** and form top surfaces of the isolation regions **54** and top surfaces of the fins **52** that are coplanar.

FIG. **5** illustrates the recessing of the isolation regions **54** to form Shallow Trench Isolation (STI) regions **54**. The isolation regions **54** are recessed such that fins **56** in the first region **50B** and in the second region **50C** protrude from between neighboring isolation regions **54**. Further, the top surfaces of the isolation regions **54** may have a flat surface as illustrated, a convex surface, a concave surface (such as dishing), or a combination thereof. The top surfaces of the isolation regions **54** may be formed flat, convex, and/or concave by an appropriate etch. The isolation regions **54** may be recessed using an acceptable etching process, such as one that is selective to the material of the isolation regions **54**. For example, a chemical oxide removal using a CER-TAS® etch or an Applied Materials SICONI tool or dilute hydrofluoric (dHF) acid may be used.

A person having ordinary skill in the art will readily understand that the process described with respect to FIGS. **2** through **5** is just one example of how fins **56** may be formed. In some embodiments, a dielectric layer can be formed over a top surface of the substrate **50**; trenches can be etched through the dielectric layer; homoepitaxial structures can be epitaxially grown in the trenches; and the dielectric layer can be recessed such that the homoepitaxial structures protrude from the dielectric layer to form fins. In still other embodiments, heteroepitaxial structures can be used for the fins. For example, the semiconductor strips **52** in FIG. **4** can be recessed, and a material different from the semiconductor strips **52** may be epitaxially grown in their place.

In some other embodiments, a dielectric layer can be formed over a top surface of the substrate **50**; trenches can be etched through the dielectric layer; heteroepitaxial structures can be epitaxially grown in the trenches using a material different from the substrate **50**; and the dielectric layer can be recessed such that the heteroepitaxial structures protrude from the dielectric layer to form fins **56**.

In some embodiments where homoepitaxial or heteroepitaxial structures are epitaxially grown, the grown materials may be in situ doped during growth, which may obviate prior and subsequent implantations although in situ and implantation doping may be used together. Still further, it may be advantageous to epitaxially grow a material in an NMOS region different from the material in a PMOS region. In various embodiments, the fins **56** may comprise silicon germanium ( $\text{Si}_x\text{Ge}_{1-x}$ , where  $x$  can be between approximately 0 and 100), silicon carbide, pure or substantially pure germanium, a III-V compound semiconductor, a II-VI compound semiconductor, or the like. For example, the available materials for forming III-V compound semiconductor include, but are not limited to, InAs, AlAs, GaAs, InP, GaN, InGaAs, InAlAs, GaSb, AlSb, AlP, GaP, and the like.

In FIG. **5**, appropriate wells may be formed in the fins **56**, fins **52**, and/or substrate **50**. For example, a P well may be formed in the first region **50B**, and an N well may be formed in the second region **50C**.

The different implant steps for the different regions **50B** and **50C** may be achieved using a photoresist or other masks (not shown). For example, a photoresist is formed over the fins **56** and the isolation regions **54** in the first region **50B**. The photoresist is patterned to expose the second region **50C** of the substrate **50**, such as a PMOS region. The photoresist can be formed by using a spin-on technique and can be patterned using acceptable photolithography techniques.

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Once the photoresist is patterned, an n-type impurity implant is performed in the second region **50C**, and the photoresist may act as a mask to substantially prevent n-type impurities from being implanted into the first region **50B**, such as an NMOS region. The n-type impurities may be phosphorus, arsenic, or the like implanted in the first region to a concentration of equal to or less than  $10^{18} \text{ cm}^{-3}$ , such as in a range from about  $10^{17} \text{ cm}^{-3}$  to about  $10^{18} \text{ cm}^{-3}$ . After the implant, the photoresist is removed, such as by an acceptable ashing process.

Following the implanting of the second region **50C**, a photoresist is formed over the fins **56** and the isolation regions **54** in the second region **50C**. The photoresist is patterned to expose the first region **50B** of the substrate **50**, such as the NMOS region. The photoresist can be formed by using a spin-on technique and can be patterned using acceptable photolithography techniques. Once the photoresist is patterned, a p-type impurity implant may be performed in the first region **50B**, and the photoresist may act as a mask to substantially prevent p-type impurities from being implanted into the second region, such as the PMOS region. The p-type impurities may be boron,  $\text{BF}_2$ , or the like implanted in the first region to a concentration of equal to or less than  $10^{18} \text{ cm}^{-3}$ , such as in a range from about  $10^{17} \text{ cm}^{-3}$  to about  $10^{18} \text{ cm}^{-3}$ . After the implant, the photoresist may be removed, such as by an acceptable ashing process.

After the implants of the first region **50B** and the second region **50C**, an anneal may be performed to activate the p-type and n-type impurities that were implanted. The implantations may form a p-well in the first region **50B**, e.g., the NMOS region, and an n-well in the second region **50C**, e.g., the PMOS region. In some embodiments, the grown materials of epitaxial fins may be in situ doped during growth, which may obviate the implantations, although in situ and implantation doping may be used together.

In FIG. **6**, a dummy dielectric layer **58** is formed on the fins **56**. The dummy dielectric layer **58** may be, for example, silicon oxide, silicon nitride, a combination thereof, or the like, and may be deposited or thermally grown according to acceptable techniques. A dummy gate layer **60** is formed over the dummy dielectric layer **58**, and a mask layer **62** is formed over the dummy gate layer **60**. The dummy gate layer **60** may be deposited over the dummy dielectric layer **58** and then planarized, such as by a CMP, an etch back process, or a combination thereof. The mask layer **62** may be deposited over the dummy gate layer **60**. The dummy gate layer **60** may be made of, for example, polysilicon or amorphous silicon, although other materials that have a high etching selectivity from the etching of isolation regions **54** may also be used. The mask layer **62** may include, for example, silicon oxide, silicon nitride, or the like. In this example, a single dummy gate layer **60** and a single mask layer **62** are formed across the first region **50B** and the second region **50C**. In other embodiments, separate dummy gate layers may be formed in the first region **50B** and the second region **50C**, and separate mask layers may be formed in the first region **50B** and the second region **50C**.

In FIGS. **7A**, **7B**, and **7C**, the mask layer **62** may be patterned using acceptable photolithography and etching techniques to form masks **72** in the first region **50B** (as illustrated in FIG. **7B**) and masks **78** in the second region **50C** (as illustrated in FIG. **7C**). The pattern of the masks **72** and **78** then may be transferred to the dummy gate layer **60** and dummy dielectric layer **58** by an acceptable etching technique to form dummy gates **70** in the first region **50B** and dummy gates **76** in the second region **50C**. The dummy gates **70** and **76** cover respective channel regions of the fins

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**56**. The dummy gates **70** and **76** may also have a lengthwise direction substantially perpendicular to the lengthwise direction of respective epitaxial fins.

In FIGS. **8A**, **8B**, and **8C**, gate seal spacers **80** can be formed on exposed surfaces of respective dummy gates **70** and **76** and/or fins **56**. A thermal oxidation or a deposition followed by an anisotropic etch may form the gate seal spacers **80**.

After the formation of the gate seal spacers **80**, implants for lightly doped source/drain (LDD) regions may be performed. Similar to the implants discussed above in FIG. **17**, a mask, such as a photoresist, may be formed over the first region **50B**, e.g., NMOS region, while exposing the second region **50C**, e.g., PMOS region, and p-type impurities may be implanted into the exposed fins **56** in the second region **50C**. The mask may then be removed. Subsequently, a mask, such as a photoresist, may be formed over the second region **50C** while exposing the first region **50B**, and n-type impurities may be implanted into the exposed fins **56** in the first region **50B**. The mask may then be removed. The n-type impurities may be the any of the n-type impurities previously discussed, and the p-type impurities may be the any of the p-type impurities previously discussed. The lightly doped source/drain regions may have a concentration of impurities of from about  $10^{15} \text{ cm}^{-3}$  to about  $10^{16} \text{ cm}^{-3}$ . An anneal may be used to activate the implanted impurities.

Further in FIGS. **8A**, **8B**, and **8C**, epitaxial source/drain regions **82** and **84** are formed in the fins **56**. In the first region **50B**, epitaxial source/drain regions **82** are formed in the fins **56** such that each dummy gate **70** is disposed between respective neighboring pairs of the epitaxial source/drain regions **82**. In some embodiments that epitaxial source/drain regions **82** may extend into the fins **52**. In the second region **50C**, epitaxial source/drain regions **84** are formed in the fins **56** such that each dummy gate **76** is disposed between respective neighboring pairs of the epitaxial source/drain regions **84**. In some embodiments that epitaxial source/drain regions **84** may extend into the fins **52**.

Epitaxial source/drain regions **82** in the first region **50B**, e.g., the NMOS region, may be formed by masking the second region **50C**, e.g., the PMOS region, and conformally depositing a dummy spacer layer in the first region **50B** followed by an anisotropic etch to form dummy gate spacers (not shown) along sidewalls of the dummy gates **70** and/or gate seal spacers **80** in the first region **50B**. Then, source/drain regions of the epitaxial fins in the first region **50B** are etched to form recesses. The epitaxial source/drain regions **82** in the first region **50B** are epitaxially grown in the recesses. The epitaxial source/drain regions **82** may include any acceptable material, such as appropriate for n-type FinFETs. For example, if the fin **56** is silicon, the epitaxial source/drain regions **82** may include silicon, SiC, SiCP, SiP, or the like. The epitaxial source/drain regions **82** may have surfaces raised from respective surfaces of the fins **56** and may have facets. Subsequently, the dummy gate spacers in the first region **50B** are removed, for example, by an etch, as is the mask on the second region **50C**.

Epitaxial source/drain regions **84** in the second region **50C**, e.g., the PMOS region, may be formed by masking the first region **50B**, e.g., the NMOS region, and conformally depositing a dummy spacer layer in the second region **50C** followed by an anisotropic etch to form dummy gate spacers (not shown) along sidewalls of the dummy gates **76** and/or gate seal spacers **80** in the second region **50C**. Then, source/drain regions of the epitaxial fins in the second region **50C** are etched to form recesses. The epitaxial source/drain regions **84** in the second region **50C** are epitaxially grown in

the recesses. The epitaxial source/drain regions **84** may include any acceptable material, such as appropriate for p-type FinFETs. For example, if the fin **56** is silicon, the epitaxial source/drain regions **84** may comprise SiGe, SiGeB, Ge, GeSn, or the like. The epitaxial source/drain regions **84** may have surfaces raised from respective surfaces of the fins **56** and may have facets. Subsequently, the dummy gate spacers in the second region **50C** are removed, for example, by an etch, as is the mask on the first region **50B**.

In FIGS. **9A**, **9B**, and **9C**, gate spacers **86** are formed on the gate seal spacers **80** along sidewalls of the dummy gates **70** and **76**. The gate spacers **86** may be formed by conformally depositing a material and subsequently anisotropically etching the material. The material of the gate spacers **86** may be silicon nitride, SiCN, carbon-containing silicon oxide, a combination thereof, or the like. The gate spacers **86** may also extend up along sidewalls of the masks **72** and **78**.

The epitaxial source/drain regions **82** and **84** and/or epitaxial fins may be implanted with dopants to form source/drain regions, similar to the process previously discussed for forming lightly doped source/drain regions, followed by an anneal. The source/drain regions may have an impurity concentration of in a range from about  $10^{19}$  cm<sup>-3</sup> to about  $10^{21}$  cm<sup>-3</sup>. The n-type impurities for source/drain regions in the first region **50B**, e.g., the NMOS region, may be any of the n-type impurities previously discussed, and the p-type impurities for source/drain regions in the second region **50C**, e.g., the PMOS region, may be any of the p-type impurities previously discussed. In other embodiments, the epitaxial source/drain regions **82** and **84** may be in situ doped during growth.

In FIGS. **10A**, **10B**, and **10C**, an ILD **88** is deposited over the structure illustrated in FIGS. **9A**, **9B**, and **9C**. In an embodiment, the ILD **88** is a flowable film formed by a flowable CVD. In some embodiments, the ILD **88** is formed of a dielectric material such as Phospho-Silicate Glass (PSG), Boro-Silicate Glass (BSG), Boron-Doped Phospho-Silicate Glass (BPSG), undoped Silicate Glass (USG), or the like, and may be deposited by any suitable method, such as CVD, spin-on coating, plasma-enhanced CVD (PECVD), or a combination thereof.

In FIGS. **11A**, **11B**, and **11C**, a planarization process, such as a CMP, may be performed to level the top surface of ILD **88** with the top surfaces of the dummy gates **70** and **76**. The CMP may also remove the masks **72** and **78** on the dummy gates **70** and **76**. Accordingly, top surfaces of the dummy gates **70** and **76** are exposed through the ILD **88**.

In FIGS. **12A**, **12B**, and **12C**, the dummy gates **70** and **76**, gate seal spacers **80**, and portions of the dummy dielectric layer **58** directly underlying the dummy gates **70** and **76** are removed in an etching step(s), so that recesses **90** are formed. Each recess **90** exposes a channel region of a respective fin **56**. Each channel region is disposed between neighboring pairs of epitaxial source/drain regions **82** and **84**. During the removal, the dummy dielectric layer **58** may be used as an etch stop layer when the dummy gates **70** and **76** are etched. The dummy dielectric layer **58** and gate seal spacers **80** may then be removed after the removal of the dummy gates **70** and **76**.

In FIGS. **13A**, **13B**, and **13C**, gate dielectric layers **92** and **96** and gate electrodes **94** and **98** are formed for replacement gates. Gate dielectric layers **92** and **96** are deposited conformally in recesses **90**, such as on the top surfaces and the sidewalls of the fins **56** and on sidewalls of the gate spacers **86**, and on a top surface of the ILD **88**. In accordance with some embodiments, gate dielectric layers **92** and **96** com-

prise silicon oxide, silicon nitride, or multilayers thereof. In other embodiments, gate dielectric layers **92** and **96** include a high-k dielectric material, and in these embodiments, gate dielectric layers **92** and **96** may have a k value greater than about 7.0, and may include a metal oxide or a silicate of Hf, Al, Zr, La, Mg, Ba, Ti, Pb, and combinations thereof. The formation methods of gate dielectric layers **92** and **96** may include Molecular-Beam Deposition (MBD), Atomic Layer Deposition (ALD), PECVD, and the like.

Next, gate electrodes **94** and **98** are deposited over gate dielectric layers **92** and **96**, respectively, and fill the remaining portions of the recesses **90**. Gate electrodes **94** and **98** may be made of a metal-containing material such as TiN, TaN, TaC, Co, Ru, Al, W, combinations thereof, or multilayers thereof. After the filling of gate electrodes **94** and **98**, in step **228**, a planarization process, such as a CMP, may be performed to remove the excess portions of gate dielectric layers **92** and **96** and the material of gate electrodes **94** and **98**, which excess portions are over the top surface of ILD **88**. The resulting remaining portions of material of gate electrodes **94** and **98** and gate dielectric layers **92** and **96** thus form replacement gates of the resulting FinFETs.

The formation of the gate dielectric layers **92** and **96** may occur simultaneously such that the gate dielectric layers **92** and **96** are made of the same materials, and the formation of the gate electrodes **94** and **98** may occur simultaneously such that the gate electrodes **94** and **98** are made of the same materials. However, in other embodiments, the gate dielectric layers **92** and **96** may be formed by distinct processes, such that the gate dielectric layers **92** and **96** may be made of different materials, and the gate electrodes **94** and **98** may be formed by distinct processes, such that the gate electrodes **94** and **98** may be made of different materials. Various masking steps may be used to mask and expose appropriate regions when using distinct processes.

In FIGS. **14A**, **14B**, and **14C**, the gate dielectric layers **92** and **96** and the gate electrodes **94** and **98** are recessed in an etching step(s), so that recesses **100** and **102** are formed. The etching step(s) may include an anisotropic dry etch. For example, the etching step(s) may include a dry etch process using reaction gas(es) that selectively etch the gate dielectric layers **92** and **96** and the gate electrodes **94** and **98** without etching the ILD **88** or the gate spacers **86**.

In FIGS. **15A**, **15B**, and **15C**, masks **104** and **106** are formed in the recesses **100** and **102**, respectively and over the gate dielectric layers **92** and **96** and the gate electrodes **94** and **98**. The masks **104** and **106** provides protection for the gate spacers **86** during subsequent self-aligned contact etching steps to ensure that the self-aligned contact does not short one of the gate electrodes **94** and **98** to the corresponding contacts for the source/drain regions **82** and **84**. The masks **104** and **106** may include, for example, silicon nitride or the like. The material composition of the masks **104** and **106** may ensure a high film density and a non-volatile etching byproduct. The masks **104** and **106** may be formed by CVD, PVD, ALD, a spin-on-dielectric process, the like, or a combination thereof. After the masks **104** and **106** are formed, a CMP may be performed so that the top surfaces of the masks **104** and **106**, the ILD **88**, and the gate spacers **86** are level.

In FIGS. **16A**, **16B**, and **16C**, openings **108** and **110** are formed through ILD **88** to expose portions of the source/drains **82** and **84**, respectively. The openings **108** and **110** may all be formed simultaneously in a same process, or in separate processes. The openings **108** and **110** may be formed using acceptable photolithography and etching techniques.

In FIGS. 17A, 17B, and 17C, conductive contacts **112** and **114** are formed in the openings **108** and **110**, respectively. A liner (not shown), such as a diffusion barrier layer, an adhesion layer, or the like, and a conductive material are formed in the openings **108** and **110**. The liner may include titanium, titanium nitride, tantalum, tantalum nitride, or the like. The conductive material may be copper, a copper alloy, silver, gold, tungsten, aluminum, nickel, cobalt, or the like. A planarization process, such as a CMP, may be performed to remove excess material from a surface of the ILD **88**. The remaining liner and conductive material form contacts **112** and **114** in the openings. An anneal process may be performed to form a silicide at the interface between the epitaxial source/drain regions **82** and **84** and the contacts **112** and **114**, respectively. Contacts **112** are physically and electrically coupled to the epitaxial source/drain regions **82**, and contacts **114** are physically and electrically coupled to the epitaxial source/drain regions **84**.

In FIGS. 18A, 18B, and 18C, the conductive contacts **112** and **114** are recessed in an etching step(s), so that recesses **116** and **118** are formed. The etching step(s) may include an anisotropic dry etch or an isotropic etch. For example, the etching step(s) may include a dry etch process using halogen-based reaction gas(es) that selectively etch the conductive contacts **112** and **114** without etching the ILD **88** or the masks **104** or **106**.

In FIGS. 19A, 19B, and 19C, masks **120** and **122** are formed in the recesses **116** and **118**, respectively, and over the conductive contacts **112** and **114**. The masks **120** and **122** provides protection for the conductive contacts **112** and **114** during subsequent contact formation above the gate electrodes **94** and **98** to ensure that the contacts do not short to the conductive contacts **112** and **114** for the source/drain regions **82** and **84**. The masks **120** and **122** may include, for example, silicon nitride (SiN), silicon oxycarbide (SiOC), silicon carbide (SiC), the like, or a combination thereof. The material composition of the masks **120** and **122** may ensure a high film density and a non-volatile etching byproduct. The masks **120** and **122** may be deposited by any suitable method, such as CVD, comprising plasma-enhanced CVD (PECVD) or a spin-on-dielectric process. In some embodiments, the plasma source of the PECVD process may be a remote plasma system. In some embodiments, the plasma source may be an inductively coupled plasma (ICP) or the like.

In some embodiments, the masks **120** and **122** are formed with a radical-containing plasma component (e.g., of a first reactive source) in combination with an unexcited component (e.g., a second reactive source) to deposit the masks **120** and **122** with the first reactive source being H<sub>2</sub>, O<sub>2</sub>, the like or a combination thereof and the second reactive source including a siloxane source and a dilute source, the dilute source being He. In some embodiments, the process temperature is in a range from about 200° C. to about 500° C., the pressure during the process is in a range from about 1 Torr to about 10 Torr. In some embodiments, the remote plasma source can use radio frequency or micro-wave with the power being in a range from about 1000 Watts to about 4000 Watts. In some embodiments, the first reactive source includes H<sub>2</sub> with its flow is in a range from about 500 Standard Cubic Centimeters per Minute (sccm) to about 25000 sccm, the first reactive source also includes O<sub>2</sub> and its flow is in a range from about 0 sccm to about 20 sccm, and the second reactive source (e.g. siloxane source) has a flow in a range from about 1 sccm to about 30 sccm.

After the masks **120** and **122** are formed, a CMP may be performed so that the top surfaces of the masks **120**, **122**, **104**, **106**, the ILD **88**, and the gate spacers **86** are level.

In FIGS. 20A, 20B, and 20C, conductive contacts **126**, **128**, **130**, and **132** are formed through masks **120**, **122**, **104**, and **106**, respectively. Openings for conductive contacts **126** and **128** are formed through the masks **120** and **122**, respectively. Openings for contacts **130** and **132** are formed through the masks **104** and **106**, respectively. These openings may all be formed simultaneously in a same process, or in separate processes. The openings may be formed using acceptable photolithography and etching techniques. A liner, such as a diffusion barrier layer, an adhesion layer, or the like, and a conductive material are formed in the openings. The liner may include titanium, titanium nitride, tantalum, tantalum nitride, or the like. The conductive material may be copper, a copper alloy, silver, gold, tungsten, aluminum, nickel, cobalt, or the like. A planarization process, such as a CMP, may be performed to remove excess material from a surface of the ILD **88** and the masks. The remaining liner and conductive material form contacts **126**, **128**, **130**, and **132** in the openings. The conductive contacts **126** are physically and electrically coupled to the conductive contacts **112**, conductive contacts **128** are physically and electrically coupled to the conductive contacts **114**, conductive contact **130** is physically and electrically coupled to the gate electrode **94**, and conductive contact **132** is physically and electrically coupled to the gate electrode **98**.

In this embodiment, the masks **104** and **106** over the gate electrodes are formed first and the masks **120** and **122** over the source/drain contacts are formed second, but, in other embodiments, the order may be reversed with the masks **120** and **122** being formed first. In other embodiments, the masks **104** and **106** are formed over the source/drain contacts and the masks **120** and **122** are formed over the gate electrodes.

Although not explicitly shown, a person having ordinary skill in the art will readily understand that further processing steps may be performed on the structure in FIGS. 20A, 20B, and 20C. For example, various IMDs and their corresponding metallizations may be formed over ILD **88**.

FIGS. 21A-21C and 22A-22C are cross-sectional views of intermediate stages in the manufacturing of FinFETs in accordance with some embodiments. The embodiment in FIGS. 21A-21C and 22A-22C is similar to the embodiments illustrated in FIGS. 2 through 20C except that this embodiment includes a liner insulation layer between the source/drain contacts **112** and **114** and the masks **120** and **122**. The materials and processing steps to arrive at the intermediate structure illustrated in FIGS. 21A-21C may be similar to the previously described embodiment in FIGS. 1 through 18C, and thus, the description is not repeated herein. Details regarding this embodiment that are similar to those for the previously described embodiment will not be repeated herein.

In FIGS. 21A, 21B, and 21C, liner insulation layers **136** and **138** are formed over the structure illustrated FIGS. 18A, 18B, and 18C and in the openings **116** and **118** over the source/drain contacts **112** and **114**. In some embodiments, the liner insulation layers **136** and **138** may be a metallic oxide or metallic nitride comprising aluminum, titanium, hafnium, zirconium, tantalum, a different metal component, the like, or a combination thereof and may be formed by ALD, CVD, the like, or a combination thereof.

In some embodiments, the ALD process for forming the liner insulation layers **136** and **138** may include a plasma process before the ALD process comprising a hydrogen contain source such as H<sub>2</sub>, NH<sub>3</sub>, the like, or a combination

thereof. The benefit of the plasma is to clean the surface and remove native oxide to improve adhesion behavior. The pressure of the plasma is in a range from about 1 Torr to about 10 Torr with the power of the plasma being in a range from about 100 Watts to about 1500 Watts.

In some embodiments, the forming of the formation of the liner insulation layers **136** and **138** may include a post-treatment of a plasma process including an H-based chemical, such as H<sub>2</sub>, NH<sub>3</sub>, the like, or a combination thereof. The benefit of the post-treatment is to densify the film by removing impurities such as organic sources. The pressure during the post-treatment is in a range from about 1 Torr to about 10 Torr and the power of the plasma being in a range from about 100 Watts to about 1500 Watts.

In some embodiments, the ALD process comprises a first reaction source being a metallic source with source flow in a range from about 10 sccm to about 300 sccm, a second reaction source being a nitrogen-containing source with source flow in a range from about 1000 sccm to about 10000 sccm. In these embodiments, the ALD process temperature is in a range from about 200° C. to about 400° C. and the pressure is in a range from about 1 Torr to about 10 Torr.

After the formation of the liner insulation layers **136** and **138**, excess liner insulation layers **136** and **138** may be removed from the top surface of the ILD **88** and the masks **104** and **106**.

In FIGS. **22A**, **22B**, and **22C**, conductive contacts **126**, **128**, **130**, and **132** are formed through masks **120**, **122**, **104**, and **106**, respectively. Openings for conductive contacts **126** and **128** are formed through the masks **120** and **122**, respectively, and the liner insulation layers **136** and **138**, respectively. Openings for contacts **130** and **132** are formed through the masks **104** and **106**, respectively. These openings may all be formed simultaneously in a same process, or in separate processes. The openings may be formed using acceptable photolithography and etching techniques. A liner, such as a diffusion barrier layer, an adhesion layer, or the like, and a conductive material are formed in the openings. The liner may include titanium, titanium nitride, tantalum, tantalum nitride, or the like. The conductive material may be copper, a copper alloy, silver, gold, tungsten, aluminum, nickel, cobalt, or the like. A planarization process, such as a CMP, may be performed to remove excess material from a surface of the ILD **88** and the masks. The remaining liner and conductive material form contacts **126**, **128**, **130**, and **132** in the openings. The conductive contacts **126** are physically and electrically coupled to the conductive contacts **112**, conductive contacts **128** are physically and electrically coupled to the conductive contacts **114**, conductive contact **130** is physically and electrically coupled to the gate electrode **94**, and conductive contact **106** is physically and electrically coupled to the gate electrode **98**.

In this embodiment, the masks **104** and **106** over the gate electrodes are formed first and the masks **120** and **122** over the source/drain contacts are formed second, but, in other embodiments, the order may be reversed with the masks **120** and **122** being formed first. In other embodiments, the masks **104** and **106** are formed over the source/drain contacts and the masks **120** and **122** are formed over the gate electrodes.

Although not explicitly shown, a person having ordinary skill in the art will readily understand that further processing steps may be performed on the structure in FIGS. **22A**, **22B**, and **22C**. For example, various IMDs and their corresponding metallizations may be formed over ILD **88**.

In some other embodiments, the conductive contacts for FinFETs are can be formed with a replacement contact technique. Replacement contacts are formed by forming a

dummy contact, and then replacing the dummy contact with the conductive contact. The dummy contacts may be formed by transferring a replacement contact pattern to a dummy contact material through tri-layer lithography, which may include patterning a mask layer on the dummy contact material, and then forming a photoresist top layer on the mask layer. A dry etch process may be used to remove a portion of the dummy contact in subsequent processing steps, and an inter-layer dielectric (ILD) may be formed around the remaining dummy contacts.

By providing self-aligning masks over both the gate electrode and the source/drain contacts, the possibility of electrical shorts/leakage between a gate electrode and source/drain contacts is reduced when forming vias to the gate electrode and/or source/drain contacts. In addition, these self-aligning masks over both the gate electrode and the source/drain contacts allows for the layout of the gate electrode to be shortened as the via to the gate electrode can be closer to the vias for the source/drain contacts. These masks over the gate electrode and the source/drain contacts ensure that the overlying vias do not electrically short the gate electrode to the source/drain contacts even when the overlying vias are misaligned.

An embodiment is a method including recessing a gate electrode over a semiconductor fin on a substrate to form a first recess from a top surface of a dielectric layer, forming a first mask in the first recess over the recessed gate electrode, recessing a first conductive contact over a source/drain region of the semiconductor fin to form a second recess from the top surface of the dielectric layer, and forming a second mask in the second recess over the recessed first conductive contact.

Another embodiment is a method including forming fins on a substrate, forming an isolation region surrounding the fins, forming a dummy gate structure over the fins, epitaxially growing source/drain regions on opposing sides of the dummy gate structure, forming an inter-layer dielectric over the isolation region and surrounding the dummy gate structure, replacing the dummy gate structure with an active gate structure, recessing the active gate structure to form a first recess, forming a first mask in the first recess, forming first conductive contacts through the inter-layer dielectric to the source/drain regions, recessing the first conductive contacts to form second recesses, and forming second masks in the second recesses.

A further embodiment is a structure including a first fin over a substrate, an isolation region surrounding lower surfaces of the first fin, a gate structure along sidewalls and over upper surfaces of the first fin, the gate structure defining a channel region in the first fin, a source/drain region on the first fin adjacent the gate structure, a dielectric layer over the isolation region and surrounding the gate structure, a first mask over the gate structure, the first mask having a top surface level with a top surface of the dielectric layer, a first conductive contact through the dielectric layer to contact the source/drain region, and a second mask over the first conductive contact, the second mask having a top surface level with the top surface of the dielectric layer.

The foregoing outlines features of several embodiments so that those skilled in the art may better understand the aspects of the present disclosure. Those skilled in the art should appreciate that they may readily use the present disclosure as a basis for designing or modifying other processes and structures for carrying out the same purposes and/or achieving the same advantages of the embodiments introduced herein. Those skilled in the art should also realize that such equivalent constructions do not depart from the

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spirit and scope of the present disclosure, and that they may make various changes, substitutions, and alterations herein without departing from the spirit and scope of the present disclosure.

What is claimed is:

1. A fin field effect transistor (FinFET) comprising:
  - a fin over a substrate;
  - an isolation region surrounding lower portions of the fin;
  - a gate structure on the fin and the isolation region;
  - a source/drain region on the fin adjacent the gate structure;
  - a dielectric layer over the isolation region and the source/drain region, the dielectric layer comprising a first recess over the gate structure and a second recess over the source/drain region;
  - a first mask in the first recess over the gate structure, the first mask extending to a top surface of the dielectric layer;
  - a first conductive contact in the second recess in the dielectric layer, the first conductive contact contacting the source/drain region; and
  - a second mask in the second recess over the first conductive contact, the second mask extending to a top surface of the dielectric layer; and
  - a second conductive contact in the second mask, the second conductive contact electrically coupled to the first conductive contact.
2. The FinFET of claim 1 further comprising:
  - a liner layer in the second recess and interposed between the first conductive contact and the second mask.
3. The FinFET of claim 2, wherein the liner layer is a metallic oxide or metallic nitride comprising aluminum, titanium, hafnium, zirconium, tantalum, or a combination thereof, and wherein the second mask comprises silicon oxynitride, silicon carbide, carbon-containing silicon oxide, or a combination thereof.
4. The FinFET of claim 2, wherein the second conductive contact extends through the second mask and the liner layer, a top surface of the second conductive contact being level with the top surface of the dielectric layer.
5. The FinFET of claim 1, wherein the material composition of the first mask is different from the material composition of the second mask.
6. The FinFET of claim 1, wherein the first mask comprises silicon nitride, and wherein the second mask comprises silicon oxynitride, silicon carbide, or a combination thereof.
7. The FinFET of claim 1 further comprising:
  - a third conductive contact in the first mask, the third conductive contact contacting the gate structure.
8. The FinFET of claim 7, wherein top surfaces of the second conductive contact and the third conductive contact are level.
9. A structure comprising:
  - an isolation region on a substrate;
  - a gate structure on the substrate and isolation region;
  - a source/drain region on the substrate, the source/drain region being adjacent the gate structure;
  - a dielectric layer over the isolation region and the source/drain region and being on sidewalls of the gate structure;
  - a first mask over the gate structure;

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- a first conductive contact over and electrically coupled to the source/drain region, a top surface of the first conductive contact being lower than a top surface of the dielectric layer; and
  - a second mask over the first conductive contact; and
  - a second conductive contact in the second mask, the second conductive contact electrically coupled to the first conductive contact.
10. The structure of claim 9 further comprising:
    - a liner layer between the first conductive contact and the second mask.
  11. The structure of claim 10, wherein the second conductive contact extends through the second mask and the liner layer, the second conductive contact electrically coupled to the first conductive contact, a top surface of the second conductive contact being level with the top surface of the dielectric layer.
  12. The structure of claim 10, wherein top surfaces of the liner layer and the second mask are level.
  13. The structure of claim 9, wherein the material composition of the first mask is different from the material composition of the second mask.
  14. The structure of claim 9, wherein the first mask comprises silicon nitride, and wherein the second mask comprises silicon oxynitride, silicon carbide, or a combination thereof.
  15. The structure of claim 9 further comprising:
    - a third conductive contact in the first mask, the third conductive contact contacting the gate structure, top surfaces of the second conductive contact and the third conductive contacts being level.
  16. A device comprising:
    - source/drain regions on a substrate;
    - a gate structure over the substrate, the gate structure being between the source/drain regions;
    - a dielectric layer over the source/drain regions;
    - a first insulation layer over the gate structure;
    - first conductive contacts over and electrically coupled to the source/drain regions, top surfaces of the first conductive contacts being lower than a top surface of the dielectric layer;
    - second insulation layers over the first conductive contacts
    - a liner layer between the first conductive contacts and the second insulation layers; and
    - second conductive contacts in the second insulation layers, the second conductive contacts electrically coupled to the first conductive contacts.
  17. The device of claim 16, wherein the second insulation layers have top surfaces level with the top surface of the dielectric layer.
  18. The device of claim 16, wherein the first insulation layer has a top surface level with the top surface of the dielectric layer.
  19. The device of claim 16 further comprising:
    - a third conductive contact in the first insulation layer, the third conductive contact contacting the gate structure, top surfaces of the second conductive contact and the third conductive contacts being level.
  20. The device of claim 16, wherein the material composition of the first insulation layer is different from the material composition of the second insulation layers.